

Dear Valued Customer,

Since 1983, Elias Woodwork has utilized the benefits of being located at the geographical center of North America. The progressive visions of the company's owners to implement Lean Manufacturing and Just In Time principles, along with the eagerness to work with other companies in a wide range of industries, has allowed us to continue to be competitive in the global market.

In the last 30 years, Elias Woodwork has been growing very rapidly. At this point in our business development we are concentrating on making improvements in the existing operations to ensure that we offer the best products and service. Elias Woodwork currently employs a large staff of hard-working and dedicated people who are proud of the products and services they provide.

With a diverse product line that continues to grow, our facility itself has grown to its current size of 400,000 sqft, this includes 28,100 sqft of staining, lacquering and painting within the facility that utilizes the latest computerized, high-quality equipment that provides top quality consistent finishes.

A major part of our production is based on building cabinet doors and refacing products for the Kitchen and Bath industry as well as for the Recreational Vehicle industry. Recently, we have added several new lines of products; custom ready to assemble cabinet boxes, a polyester-saturated paper on MDF cabinet door line (FPL), a high gloss acrylic line of cabinet doors and many new Thermofoil colors, plus a greatly expanded wood species selection.

With the growth potential we identified in our beginnings has come the opportunity to service customers outside of Manitoba and outside of Canada. The world is becoming a smaller place every day and products can be sold and shipped all around the world. Every day we are shipping to cabinet shops, commercial millwork shops, and refacing companies in the United States and Canada. International trade has become very important to us and we hope to cultivate the relationships necessary to sustain growth in this area.



It gives us great pleasure to present our products and services to you in this catalog. There are still many products we provide that are not present here, as we are able to manufacture almost any custom wood product. We invite you to request any products you might need that are not considered 'standard' for our industry.

We hope that your experience with Elias Woodwork will be pleasant and beneficial for your company. We look forward to working with and for you.

Sincerely,

Ralph D. Fehr

## Office Hours

Our office hours are 8:00 a.m. to 4:30 p.m. Central Time, Monday to Friday. During these hours you can expect the phone to be answered by a human being. Orders, quote requests, and inquiries can be sent by email 24 hours a day, 7 days a week.

## Quotes

Get instant quotes anytime from anywhere with AccessNow online ordering. Manage your account, get inside product pricing, track shipments, make payments and much more. See our website for video tutorials or speak to your Customer Service Specialist.

In the woodworking industry, many projects can call for non-standard items that we don't show in our catalog, website or AccessNow, but are needed in order to quote or complete a project. Please phone or email all information and dimensions of such items as completely as possible so that an Elias Woodwork Customer Service Specialist (CSS) may provide you with an accurate quote as promptly as possible.

## Ordering

Orders can be placed online in AccessNow, by email, phone, and mail. Fillable Order Forms can also be downloaded from our website or sent to you at any time, just contact your Elias Woodwork Customer Service Specialist.

Email: [orderdesk@eliaswoodwork.com](mailto:orderdesk@eliaswoodwork.com)

Toll Free: 1-800-665-0623

Local: 1-204-325-9962

Mail: Box 1659, Winkler Manitoba  
Canada, R6W 4B5

Shipping: 275 Badger Ave, Winkler  
Manitoba Canada, R6W OK5

## Payment Policy

Elias Woodwork requires all orders to be prepaid with your VISA or MASTERCARD until credit terms have been established. You can apply payments in your AccessNow account or through your Customer Service Specialist. If you would like to apply for credit, please contact our credit department and ask to have a credit application forwarded to you.

## Credit Cards

Elias Woodwork is a verified Authorize.Net merchant. All credit card transactions are processed through our AccessNow payment portal via Authorize.Net so you can be confident that all transactions are processed according to the highest security standards. Transactions are processed in your home currency, unless otherwise noted. For more information, please contact your Customer Service Specialist.

## Changes

Within hours of receiving your order confirmation, we put your order into production. Occasionally it happens that after you have sent your confirmation back, you need to make changes to your order. Changes cannot be made after we receive your approved confirmation, you will need to re-order the items.

## Expedited Production – The Service Matrix

Elias Woodwork strives to provide quick order lead times on all products in an effort to help your business run smoothly. However, there are situations where you may need a few parts, or even an entire order quicker than usual. This is where the Elias Woodwork Service Matrix can help. Our Scheduling Team can provide quotes for lead times as little as 3 days, depending on the product. While this expedited production service does cost more, it can be well worth it to complete your job on time. We will quote all upcharges ahead of time so you can make a quick, informed decision. Most orders will be quoted with three production time options, including Economy, Priority Plus and Urgent Express. Quoted lead times begin when all order details are clear and the order confirmation has been received.

The Service Matrix refers only to production lead times. Expedited shipping such as Next Day Air is available, but it must be specifically requested. We can also provide freight quotes as requested.

## Freight

Within Canada: Small orders will generally be shipped by either Purolator or UPS. Larger orders will generally be shipped by one of a number of different LTL carriers. Elias will

carefully choose the freight provider for you, basing the decision on past performance of the carrier and also considering your location. If you have a preferred carrier please let an Elias Customer Service Specialist know prior to shipping.

**Within USA:** Small orders will generally be shipped by FedEx or UPS. Larger orders will generally be shipped by one of a number of different LTL carriers. Elias will carefully choose the freight provider for you, basing the decision on past performance of the carrier and also on your location. If you have a preferred carrier please let an Elias Customer Service Specialist know prior to shipping.

### Freight Costs

We offer FREE shipping on any shipment that qualifies for prepaid freight. If the order does not qualify for prepaid freight, the order will be shipped out prepaid and the freight charge will be added to the Elias invoice. This procedure allows you to take advantage of Elias Woodwork's bulk rates and prevents having to set up accounts at various freight companies. Note: Elias Woodwork reserves the right to charge any Accessorial freight charges by the freight company to your account at a later date.

**PREPAID FREIGHT:** To qualify for prepaid freight your order must include a minimum of 30 five piece wood cabinet doors.

Note: Some exceptions may apply. Speak to a Customer Service Specialist.

### Freight Damage Claims

Please closely follow these detailed instructions regarding freight damage claims.

Inspect your shipment when it is delivered.

Before the delivery driver leaves:

- a. Look for any damage on the exterior of the package. If any damage is noted, please sign the waybill and add a note: "received but damage noted, subject to further inspection". If there is room on the waybill, be specific. For example, "side of crate missing" or "crate broken". Take a photo of the damaged crate or box. Please send your CSS an email to let them know what happened; include your photo and a copy of

the waybill.

- b. If there is no damage noted to the outside, please sign the waybill: "received, subject to further inspection". Occasionally damage will occur inside the crate or box from rough handling between our shipping dock and your receiving dock.

Open all packages and inspect all pieces within one week of receiving your shipment. Count all items to make sure the number of pieces received matches your packing slip included with your shipment. Remember, Elias Woodwork will not be liable for any damages caused by improper handling or storage of our product. Please refer to our warranty information on our website or in our catalog for more information.

- a. If you are missing an item(s) from your packing slip, please call or email your CSS and reference the line number(s) or product details from your packing slip. Report this as soon as possible to allow for an investigation of item(s) not ordered or left behind on our dock.
- b. Take photo(s) of any item(s) that have been damaged in transit. Find the corresponding line number(s) and report to your CSS via email. Make sure to include a clear and focused photo of the problem area(s) and a picture of the entire item where applicable so that the problem is obvious. Include photos of damaged packaging where at all possible. Where a short (10-15 seconds) video seems more appropriate, please feel free to send those as well. Requests for replacements without photos as requested will not be covered by Elias Woodwork.
  - i. Transit Damages, Scratches & Dents or Cracks – take your photo from an angle which shows the problem clearly. Make sure that none of these scratches or dents are from knives or improper stacking while unpackaging.
- c. For any other errors on your shipment, please document with a clear and focused photo and report to your CSS, making sure to include an explanation of the error.
  - I. Open joints or Warping – frequently happens due to environmental causes – please refer to our warranty and specific product handling information on our website or in our catalog for

more information regarding tolerances in warping due to size. Keep all products in a humidity-controlled environment at all times. Open joints can occur on doors that have been dropped. Please report and photograph any damages to the structure of the door.

- ii. Wrong Size – using a measuring tape, show in the photo the incorrect measurement. Either metric or standard measuring tapes are acceptable but please make sure to use the same system as the order was placed. (It is recommended, but not required that you start the tape at 1” or 1cm for best accuracy.) Please refer to our warranty information on our website or in our catalog for more information regarding tolerances and sizing. Compare the size measured to the size on the order to verify that size has been ordered and/or entered correctly.
- iii. Wrong Color – take a photo; compare the information from your packing slip and your purchase order to verify that the order was correct and/or entered correctly.
- iv. Out of Square – using a square or tape measuring from opposing corners, include the entire item in the photo if possible, if not send additional photos.
- v. Warped – lay the item on a flat surface and take your photo from either end. Please refer to our warranty information on our website or in our catalog for more information regarding tolerances in warping due to size.
- vi. Hinge Drilling or Finger Pull error – document the error with a photo and send to your CSS. Make sure to reference the line number from your packing slip.
- vii. All delivery-related problems must be reported no later than four (but preferably within one) weeks from date of receipt.

\*\* Remember that our product is covered by our warranty to arrive without defect in workmanship and material for a limited time, but does not cover any damages caused by

improper handling after delivery and/or installation. Please see the Warranty Section of our website or catalog for full details on each of our product lines. \*\*

### Accessorial Charges

Accessorial charges are extra fees attached to transportation services for duties beyond simply shipping goods from point A to point B. Examples of services and approximate costs include: waiting time, storage, packing, extra fuel, power lift-gate, calling before delivery, residential delivery, re-delivery of freight, breaking down a skid, etc. These examples are only a few of the charges that can occur but they reflect the ones most applicable to our industry. The cost for these services will vary between different LTL carriers. If your order qualifies for our FREE shipping, these accessorial charges are not included in the flat rate shipping cost. Elias Woodwork does not discourage the use of the services, but wants you to be aware of any additional costs association with shipping. Please ask your Customer Service Specialist to obtain rates for you prior to your order leaving Elias Woodwork. If your shipment requires a carrier offered service while in transit Elias Woodwork reserves the right to pass on the charge to you as the fee is realized.

- Call before delivery: \$5 - \$25
- Power lift-gate: \$75 - \$125
- Residential delivery: \$75 - \$250
- Re-delivery of freight: \$100 - \$150
- Break down skid at delivery: \$145

### Packaging

Elias Woodwork packages its product to help ensure its arrival to your location free of damage. It is important to inform an Elias Woodwork Customer Service Specialist if you do not have forklift availability. This will determine packaging techniques used for your product so that you are able to receive the product efficiently and it will remain damage free. Most packaging required to ensure the safety of your product is done FREE of CHARGE.

### Remakes / Replacement Products:

If Elias Woodwork makes a mistake on your order, or if freight damage has occurred, we will replace the products on our Priority Plus service

level at no charge. These products will be shipped by the standard Ground service. It can be upgraded to Air service at your request. With this request, you will be required to cover the cost difference between the Ground and Air service. Please email photos and a complete description of the issue so we can complete the warranty process as quickly as possible.

### Custom Products

From custom table legs to custom radius cabinet doors, Elias Woodwork is equipped to produce whatever product you need to complete that next project. Elias Woodwork has grown over the years by helping our customers satisfy their customers with the final product they were expecting and for a reasonable price.

Elias Woodwork is equipped with a wide variety of state of the art equipment and skilled crafts people, which means we are able to produce many items not shown in this catalog. We can usually manufacture the item to the specs that you supply; simply send us a drawing or a description! We regularly manufacture custom parts for many different industries, from Residential Kitchens to Commercial Millwork to Recreational Vehicles and more!

### New Products

Elias Woodwork is constantly adding new products to our extensive product selection. Many new miter frame profiles, panel profiles, outside edge profiles, applied molding profiles and molding / millwork profiles are consistently being designed and produced. If you need something which you do not see in our catalog, please contact your Customer Service Specialist for information on new products and profiles. You may also physically send us a drawing or template by mail or email and we will advise if we already have the product, or something similar.

### Warranty

Elias Woodwork warrants that its wood cabinet doors and drawer fronts will be free from defect in workmanship and material for one year from the date of shipment. The beauty of natural wood does allow for limited amounts of natural characteristics of wood to show.

Elias Woodwork will not be liable for any

damages caused by improper handling, storage or installation of our product. Elias Woodwork will not be liable for any costs incurred by the customer for finishing, removal, installation, travel, or labor of any kind, nor any other product used with our products. This warranty covers only the replacement of our product as ordered by the customer, and the shipping charges to and from Elias Woodwork.

Due to the natural expansion and contraction of wood, any product with a laminated panel over 24" wide will carry no warranty. This includes but is not limited to raised panel doors and drawer fronts.

Elias Woodwork will void warranty if an "unfinished or raw" wood product is not sealed properly within a reasonable amount of time after receiving, as we cannot be responsible for the conditions affecting the product in an unprotected state.

Over time during the normal use of doors and drawer fronts with a colored lacquer (painted) finish, a non structural hairline crack in the finish may appear on the joints of the doors / drawer fronts. This type of crack in no way jeopardizes the structural soundness of the product, it is merely an aesthetic characteristic which is considered normal in a colored lacquer finish and is not covered by warranty.

### Warranty and Customer Care Issues one week or more after delivery

1. Document the item with a photo. All photos should be clear and focused on the area of concern. We may request additional photos where criteria is not met.
  - a. Scratches & Dents or Cracks – take your photo from an angle that shows the problem clearly.
  - b. Open joints – frequently happens due to environmental causes – please refer to our warranty and specific product handling information on our website for more information regarding the environment in which our products are installed. Please include in your request for replacement the relative humidity of the home.
  - c. Warped – lay the item on a flat surface and take your photo from either end. Please refer to our warranty information on our

website or in our catalog for more information regarding tolerances in warping due to size.

- d. Wood grain or discolorations – please refer to the Wood Grade section of our website or catalog. If the product you received does not match the description there or on the back of the sample you received, please send a photo to your CSS with an explanation.
  - e. Problem with the Finish – take a clear and focused photo of the problem and send to your CSS. They may refer you to the handout that was included with your shipment regarding care of your product or to the Product Care & Handling page on our website.
  - f. Hardware issues – take a photo or video showing the problem.
2. Find the original PO or Elias sales order number or invoice number and circle or highlight the line item from that document.
  3. Report to your CSS. Include as many other relevant details as possible.
  4. We may request that the product be returned to us for further evaluation, testing or employee training.
  5. In order to proceed as quickly as possible, an estimate form will be sent to you upon receiving the request, please confirm the details and return. The order may or may not show a cost at this time while the request is being reviewed by the warranty team. If you do not wish to proceed with the replacement prior to request approval, please let your CSS know.

### Confirmations

#### The Purpose:

To ensure that all information regarding wood species and grade, profiles, sizes, finish, customer information and ship date are correct and/or acceptable to the customer. Every order sent to Elias Woodwork will have a confirmation sent back to the customer to verify that we understand what you want. Production will not begin until a signed confirmation is received unless otherwise arranged.

#### How to Use / Read:

Order confirmations will be sent via email. Once received, please carefully read the instructions on the order confirmation. Check all information

including all the product details, finish, quantities and sizes, as well as your shipping address and any special delivery requirements.

The estimated ship date shown will only take effect when the confirmation has been received by Elias Woodwork. The ship date shown on the confirmation is only valid if you confirm the order by the date and time specified, usually the morning of the following business day.

If your customers require faster lead times, don't forget that you can change your ship date by taking advantage of our rush service levels.

## Wood Grades

Please read the following descriptions of our wood species and grades carefully when selecting a wood species for your order. If you have more questions regarding color matching or panel stave sizes, please call your Customer Service Specialist. Please also note that because climate and ecosystems across North America are so diverse, no two trees are exactly alike so neither will two boards be exactly alike. If you would like a closer look at a specific grade, we recommend that you order a sample. Based on our experiences with wood, we have also made some finishing recommendations for each wood species and grade. For instance, if you are planning on using a clear or light finish, please choose either the select or premium grade.

### Alder, Flat Cut

**Clear** – Color on this type of door will be fairly uniform with consistent grain structure. You will receive a light brown color matched door free of knots. This type of door is usually finished with a light colored spray stain.

**Knotty** – Color on this type of door will be fairly uniform but grain variations and knots of all types and sizes will be present. It should be noted that alder knots usually contain slightly opened cracks or are pitted. Even though the knots are pitted, an attempt is made to make sure they are not completely through the door. This type of door is usually finished with a light colored spray stain.

## Cherry, Flat Cut

**Natural** – Is our most economical grade of Cherry. A variety of color and grain variations including sapwood and a moderate amount of pitch marks and/or pin knots are randomly assembled to yield an attractive door with lively character. Virtually any spray stain finish colors work well on this wood grade depending on taste.

**Select** – Is our standard grade of Cherry. Color and grain variations are only tolerated to a limited degree. The color is fairly uniform with little or no sapwood and well matched. Moderate color variations are allowed between doors. A few small pitch marks and/or pin knots may be allowed and some sapwood and or mineral streaks may be found in machined areas. This wood grade is well suited to most applications where medium to light spray stain finishes are required.

**Premium** – Is our finest grade of Cherry. Color and grain uniformity are assured. All products in a given order are made from material of the same color and grain characteristics with very low tolerance for pitch marks, sapwood, and pin knots or variations in machined areas. This wood grade is of excellent quality and perfect for clear or light finishes or where customers expectations of color uniformity are extremely high.

**Rustic** – Is a special designer grade of Cherry with enhanced character. Color, grain variations, and smaller knots including a limited amount of sapwood and a large amount of pitch marks are matched to result in a unique and expensive old world look. Virtually any finish colors in spray stains work well on this wood grade depending on taste.

## Hickory, Flat Cut (sometimes called Pecan)

**Premium** – In our Premium grade of Hickory cabinet doors you will receive a calico look in each door. Sapwood and heartwood are matched and blended to flow through the panel in such a way as to minimize abrupt color changes along lamination lines. This is a very attractive, natural looking door and is usually finished clear but most light spray stains work well on this door.

**Rustic** – Our Rustic grade of Hickory is our most colorful grade. Color and grain variations including sapwood and heartwood are included in each door producing a door that has colors that range from whites to blacks. Closed knots, mineral staining, and pitch marks are allowed throughout. Doors in this wood type are usually finished clear but most light spray stains work well on this door.

## Mahogany, African Flat Cut

**Select** – African Mahogany has a pale reddish-brown color with a straight, interlocking grain. The irregular patches or streaks in the grain produce beautiful dark and light bands of color when finished. It is free of knots and suited for clear coats to dark stains.

## Maple/HDF (Paint Grade)

Our most common paint grade cabinet door and our standard default is manufactured with a Hard Maple frame and an HDF panel. This product is best suited for a solid colored lacquer or "paint" finish. Please specify other combinations if required.

## Pine, Flat Cut (Eastern White)

**Knotty** – Is our most popular grade of Pine. Color, grain variations, knots, and other natural characteristics are selected and matched to produce an attractive product. Large knots are avoided in stile material to avoid warping. An attempt is made to ensure knots in panels are well spaced, will remain tight, and are not generally in machined areas. This wood grade is usually finished clear or with very light spray stains to avoid the blotchiness often associated with wipe on stains.

**Clear** – Clear Pine yields an inexpensive clear lightly colored wood product. Color and grain variations are selected and matched to produce a fairly uniform light colored door. This wood grade is usually finished clear or with very light spray stains to avoid the blotchiness often associated with wipe on stains.

### Red Oak, Flat Cut

**Natural** – Is our most economical grade of Oak. Color and grain variations are allowed with a time limited effort in matching. Mineral stain, sapwood, and a limited number of pin knots are allowed with the best side turned forward at glue up. Machining quality is the same as any other grade. This wood grade is best suited to medium to dark finishes or spray stains with hiding characteristics.

**Select** – Is our standard grade used for Oak products. Color and grain variations are held to closer tolerances than in a Natural grade. The color is fairly uniform and well matched. Moderate color variations are allowed between doors. A few of the smallest pin knots may be allowed along with a small amount of mineral streaks and sapwood allowed in machined areas. This wood grade is well suited to most applications where lighter spray or wipe stain finishes are specified.

**Premium** – Is our top grade of Oak. Color and grain uniformity are assured. All doors in a given order are made from material of the same color and grain characteristics with very low tolerance for variations in machined areas. This door is of impeccable quality and perfect for clear or light spray or wipe stain finishes where extremely quality conscious customers are involved.

### Red Oak, Quarter Cut

**Select** – Color and grain variations are only tolerated to a limited degree. The color is fairly uniform and well matched. Moderate color variations are allowed between doors. A few of the smallest pin knots may be allowed along with a small amount of mineral streaks and sapwood allowed in machined areas. Being Quarter Cut, this wood type creates a fairly 'straight grain' look with an emphasis being placed on choosing material with ray flakes. This wood grade is well suited to most applications where light to medium spray or wipe stain finishes are specified.

### Red Oak, Rift Cut

**Select** – Color and grain variations are only tolerated to a limited degree. The color is fairly uniform and well matched. Moderate color variations are allowed between doors. A few of the smallest pin knots may be allowed along with a small amount of mineral streaks and sapwood allowed in machined areas. Being Rift Cut, this wood type minimizes the ray flakes in the Red Oak and creates a fairly 'straight grain' look. This wood grade is well suited to most applications where light to medium spray or wipe stain finishes are specified.

### Walnut, Flat Cut

**Select** – Is our standard grade of Walnut. Color and grain variations are tolerated to a limited degree. The color variation is fairly uniform allowing the lighter colors to appear only in some deeper profiles and on the back side of the door. A few pin knots and small knot clusters may be allowed if overall color is consistent. This wood grade is well suited for light stains to dark stains.

**Rustic** – Color variations and knots are purposely selected. The color may vary from a light creamy white to rich dark browns and this color variation may appear in some of the deeper profiles and on both the front and back faces of the door. The color variation together with the fact that we make sure each door has knots in the face of the door gives this wood grade a completely different look than our select grade. Walnut knots tend to be pitted and cracked in the knot area but you should not be able to see through them. This grade is well suited for all types of finish, depending on personal preference.

### White Oak, Flat Cut

**Select** – Is our standard grade of White Oak. Color and grain variations are only tolerated to a limited degree. The color is fairly uniform and well matched. Moderate color variations are allowed between doors, with a few small pin knots being allowed. This wood grade is well suited to most applications where light to medium stain finishes are specified.

**White Oak, Rift Cut**

**Select** – Color and grain variations are only tolerated to a limited degree. The color is fairly uniform and well matched. Moderate color variations are allowed between doors. A few of the smallest pin knots may be allowed along with a small amount of mineral streaks and sapwood allowed in machined areas. Being Rift Cut, this wood type minimizes the ray flakes in the White Oak and creates a fairly 'straight grain' look. This wood grade is well suited to most applications where light to medium spray or wipe stain finishes are specified.

**White Oak, Quarter Cut**

**Select** – Color and grain variations are only tolerated to a limited degree. The color is fairly uniform and well matched. Moderate color variations are allowed between doors. A few of the smallest pin knots may be allowed along with a small amount of mineral streaks and sapwood allowed in machined areas. Being Quarter Cut, this wood type creates a fairly 'straight grain' look with an emphasis being placed on choosing material with ray flakes. This wood grade is well suited to most applications where light to medium spray or wipe stain finishes are specified.

**White Maple, Flat Cut**

**Soft** – Is the most economical wood grade. Color and grain variations along with mineral stained and brown or green heartwood are allowed with no effort given to matching. Machining quality is the same as any other grade. This wood grade is best suited for drawer boxes and solid color paints with good hiding characteristics.

**Natural** – Is an economical grade of Maple for cabinet doors. Color and grain variations along with mineral staining and brown heartwood are purposely encouraged with a time limited effort in matching. Machining quality is the same as any other grade. This wood grade is best suited to medium to dark spray stains with some hiding characteristics.

**Select** – Is our standard grade for Maple products. Color and grain variations are only tolerated to a limited degree. The color is fairly uniform and well matched. Moderate color variations are allowed between doors. A few of the smallest pin knots may be allowed along with a small amount of mineral streaks and brown heartwood allowed in machined areas. This wood grade is well suited to most applications where medium to light spray stain finishes are specified.

**Premium** – Is our finest grade of Maple. Color and grain uniformity are assured. All doors in a given order are made from material of the same color and grain characteristics with very low tolerance for variations in machined areas. This wood grade is of excellent quality and perfect for clear or light spray stain finishes or where customers demand a near "plastic laminate" quality look.

**Yellow Poplar, Flat Cut**

**Select** - Is fine textured, soft and lightweight. Yellow Poplar has grayish-white sapwood with greenish brown heartwood so the color ranges from a light green to an off white. It machines well and takes paint exceptionally well. Poplar is frequently finished to look like other woods, and also works well as a paint grade wood. This grade is free of knots.

# Prefinishing

## Top Coats, Stains, Paints and Glazes

We understand the important role that kitchen and bath cabinetry play in defining a home's personality. Research has shown that over 80% of purchases are made based on the color of these two important rooms. Having a large selection of colors and wood species available is essential in today's rapidly changing market. With the consumer's ability to experience different colors, wood species and textures through mediums such as the internet and magazines, the market place goes through "the in-thing" at an alarming rate. These trends naturally create an appetite for new colors very quickly. These rapid changes in style have forced all cabinet manufacturers to increase their selection of stain, paint and glaze colors and techniques on a larger selection of wood species than ever before. Our collaboration with world-renowned color experts, including those with the Akzo Nobel and Axalta, gives us a distinct advantage in this area. This knowledge, in turn, enables our customers to offer the most desirable products to the marketplace. Elias Woodwork's selection of products is constantly evolving and our design team is working hard at keeping up with the fast pace of change in today's kitchen and bath industry.

The following section of the catalog is devoted to explaining the products, equipment and procedures used to achieve the top quality coatings that we are proud to offer. Elias Woodwork works hard to maintain the best quality and step-by-step procedures for all stains, paints, glazes and top coats and our goal is that you will notice the difference.

We are constantly driven to making our industry more sustainable. Our products are formulated to have a reduced impact on the environment without sacrificing performance and durability. Over-spray that occurs on the flat line spray machines is captured and remixed back into the system keeping waste to a minimum.

### Clear Coats

Elias Woodwork uses a 35° (degree) post catalyzed lacquer (conversion varnish) as the standard sheen for clear finishes. Clear coats are applied onto the product by machine while lying horizontally to achieve a high solids, no sag, no run finish. It is then transferred directly into a flash-off oven. This oven has a controlled environment and temperature. The oven is key to preventing airborne particle contamination of

the top coat. The result of this process is a clear coat that measures approximately 3.2 mm thick with very little to no airborne particle contamination.

### Stains

Elias Woodwork offers a large range of standard stain colors on a large variety of wood species. Each of the stain colors has been chosen by industry experts and represents the latest trends in color and fashion. These finishes are applied in a variety of different ways. From traditional wipe-on stains and no-touch spray stains to multi-step combination stains. Each stain color and application technique is carefully developed in collaboration with the experts at Akzo Nobel Coatings. The chemists from Akzo Nobel are at the Elias Woodwork facility during stain development and testing. Together, we work to develop colors and techniques that your company will benefit from. Stains are carefully developed with the following principles: pleasing to the consumer, repeatable by our production department and economical for you. Elias Woodwork uses machines when applying stains wherever possible which helps maintain consistency and reduce application cost. To maintain consistency we keep two complete sets of color samples on file for reference. One of these sets of samples is safely stored outside of our spray facility and protected from the degrading effects of light. The other set is kept in the spray booth and is compared to all finished product, to help maintain color consistency. Elias Woodwork has dedicated full-time personnel whose job it is to study and maintain stain and colors. These people understand the factors that impact the final color. We carefully consider species and the different lighting sources in the development process of our stain colors. We understand the importance of color and how it will show. A 35° sheen top coat is standard on all stained products.

NOTE: The final color of any wood stain is always a combination of the stain itself, and the color of the underlying raw wood. No two trees are the same, and some range in finish color should be expected due to variations in raw wood color, grain, texture, density, and age. Darker stains will more readily hide the color variations within a given wood species. The lighter the stain finish, the more the natural woodgrain and color variations will show through.

**SPRAY STAIN:** Our spray stains are applied by spraying the stain onto the product and allowing it to dry. Spray equipment and spraying technique are major factors that influence the color and look of a spray stain. We apply our spray stains using machines whenever possible, in order to ensure more color and finish consistency. As with any stain finish, solid lumber and veneer of the same species may not match exactly, due to the fact that veneer tends to absorb stain more readily than solid wood. Only experienced finishers should attempt to apply spray-stain finishes.

**WIPE STAIN:** Our wipe stains are applied by spraying the stain onto the product, and then immediately wiping it off with a rag. It's important to note that a wipe stain can result in a somewhat blotchy "rustic" look, depending on the wood grade and species. Maple is a common species that is particularly prone to this blotchy "rustic" wipe stain effect. The color and darkness of a given wipe stain can also appear significantly different on solid wood versus veneer, which is particularly noticeable on plywood panel shaker doors with solid wood frames. Wipe stains can result in a very pleasant look, depending on taste, and are best suited to individuals who are comfortable with more color variation across their product.

All of Elias Woodwork's standard stain colors can be purchased separately in one litre or four litre quantities. Touch up stain pens and fill sticks are also available in select colors.

Please ask your Customer Service Specialist for a complete stain sample set.

### **Priming Only**

When "prime only" is required the following should be expected:

**Molding** – Our standard procedure is to use a white primer and spray the face and edges of the molding only. The molding will not be scuff sanded after the primer has been applied. Please inquire if different specifications are required.

**Raised panel cabinet doors** – The MDF raised panel will be primed with white primer prior to assembly. The flat surface of the panel and the profiled edge of the panel will be scuff sanded prior to assembly of the door, then the entire door will be primed with white primer. After this

coat of primer has been applied the door is not scuff sanded. Please inquire if different specifications are required.

**Recessed panel cabinet doors** – MDF flat insert panels will be primed with white primer prior to assembly, then the entire door will be primed with white primer. After this coat of primer has been applied the door is not scuff sanded. Please inquire if different specifications are required.

**Miscellaneous Accessories** – Most accessories can be primed. Our standard default primer color is white. After the primer has been applied the accessories are not scuff sanded. Please inquire if different specifications are required.

### **Solid Colors (Painted)**

Elias Woodwork offers a full solid color (i.e. paint) selection. The standard sheen of solid color finishes is 10°. The solid colors are machine sprayed and oven dried. The product is machine sprayed horizontally to achieve high solids, with a no-sag, no-run finish. It is then machine transferred directly into flash-off ovens. These ovens are environment and heat controlled. The ovens are key to preventing airborne particle contamination from getting trapped in the top coats. The result of this process is a coat that measures approximately 3.2 mm thick with very little to no airborne particle contamination. Our glazes and different glaze techniques can be added to the solid colors, creating many different eye pleasing combinations. We have a standard solid color selection, please ask for a full sample color chain. Custom color formulations or matches are possible; please ask a Customer Service Specialist for more information.

### **Sheen**

Standard sheen (default for stained or clear coated products) = 35°

Low sheen (default for solid color lacquers i.e. paint) = 10° / Gloss sheen = 45°

### **Touch Up Kits**

Elias Woodwork stocks touch up kits to match many of our most popular stain, paint, RTF and DLV colors. These kits are user friendly and can be very useful for quick repairs to put the finishing touch on your job. Both pens and putty sticks are available.

### Glazes

Elias Woodwork offers glaze finishes that can be used together with any of our clear, stained or painted finishes. Our standard glaze is a dry type and is applied using the old world techniques. We also work with wet glazes, and when used together with solid color paints, this creates a look from a different time (brushstroke glaze technique uses a wet glaze). Elias Woodwork personnel apply glazes by hand, let them dry and finish the technique by hand, leaving a glazed finish that gives our new product an old look. We find there is no substitute to this age old hand process and no machine can duplicate a natural looking glaze finish. Every piece that you see is a piece of art; it is done by hand, adding to its unique look. Elias offers four different glazing techniques. Adding glaze to a beautifully finished cabinet door produces abundant opportunities. Glazes can be added to any type of finish: clear coat, stain or solid color. Please ask your Customer Service Specialist for more details.

### Glaze Techniques Defined

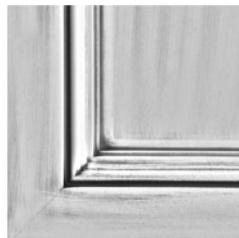
#### Artisan Glaze

This technique produces straight, clean glaze lines. The glaze is sprayed onto the cabinet door, and then hand-rubbed off, remaining in the grooves and corners of the cabinet door. The part of the product that does not have glaze on it will be cleaned off entirely, giving a crisp and clean contrast between the glazed and non-glazed areas. (Elias code = "A")



#### Feathered Glaze

This technique has a heavier build of glaze in the deeper grooves and fades off into the smooth flat areas. The Feathered technique allows for some glaze to appear on the smooth surfaces but will be most concentrated in the grooves and corners of the doors. Most would agree that this look gives you a more "old" or "antiqued" look. (Elias code = "F")



#### Brushstroke Glaze

This wet glaze does not dry instantly and can be "worked with" while wet for a short period of time. We manipulate the wet glaze with a brush, creating a "grain" direction on the surface of the door. This technique reproduces a look similar to an antique cabinet door, recreating the feeling of a home from another time. (Elias code = "B")



### Product Aging Techniques

The art of producing a product that appears old and antique is a highly subjective topic. We work hard to create a piece of art out of every cabinet door while also trying to maintain uniformity throughout the entire kitchen. We understand that every kitchen needs to look naturally aged, creating the feeling of an old, quality made and timeless piece of furniture. Our goal is to create the appearance and feeling of quality made woodwork that was produced one hundred years ago, when handwork prevailed and longevity was paramount. The aging process is done by hand and carefully follows our proprietary process, ensuring a systematic, consistent outcome. We have succeeded in creating a correctly aged door when you find yourself saying; "I wish these doors could talk because I am sure they have a story to tell." Please read the following to help understand the differences in our techniques.

### **Please note the following defaults with our aged cabinet doors.**

All of our aging techniques are applied to solid wood, raised panel cabinet doors. Through research we have found the following Elias Woodwork profile closely represents the correct time period and compliments this aging process - Code = E500, 201(57.2 Stile width), O (panel), B (outside edge). We always protect our products after aging with a 10° (low sheen) clear top coat. When an order includes parts and accessories - such as moldings, corbels and valances - we always apply the same aging technique to all of the parts to maintain a uniform appearance. We will not by default do the aging process to veneers or plywood products as this process generally will break through the veneers and make that product unusable.

Default door used for Aged door with a 2 1/4" frame is called: **NOBEL** (E500, 201 (57.2), O, B)

Default door used for Aged door with a 3" frame is called: **ROYAL** (E500, 201 (76.2), O, B)

### Default Wood Type for the Aging Process

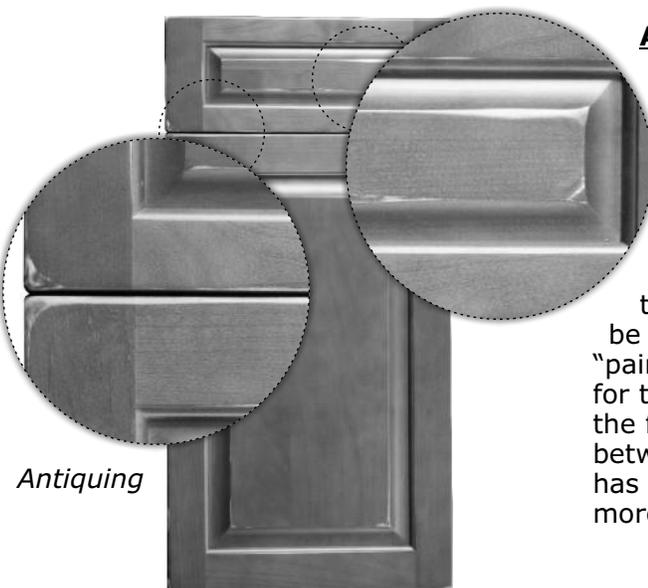
Cherry or Alder are the recommended wood species when manufacturing cabinet doors and accessories for the aging process. Poplar can be substituted for Cherry or Alder when solid color paint is the chosen finish. Wood species such as Oak, Maple, Bamboo and Hickory are too dense and do not lend themselves to the aging process.

### Aging Techniques Defined

**Rub-Through** involves some corners and edges getting sanded to create a tasteful yet slightly old look. As the name suggests, the sanding on this technique does not round the corners aggressively but only removes a minor amount of wood. Outside corners and raised panel corners of the cabinet doors are sanded off prior to the stain/paint process and then sanded again after the staining/painting process. Some of the sharper edges are sanded off after the stain/paint process to help create the look of heavy use. The finished product is clear coated to preserve the look and seal up the raw wood that was exposed in the sanding process. This creates a very elegant look while creating the feel of an old high-quality kitchen. The Rub-Through technique is the least aggressive of our aging looks. (Elias code = "RT")



*Rub-Through*

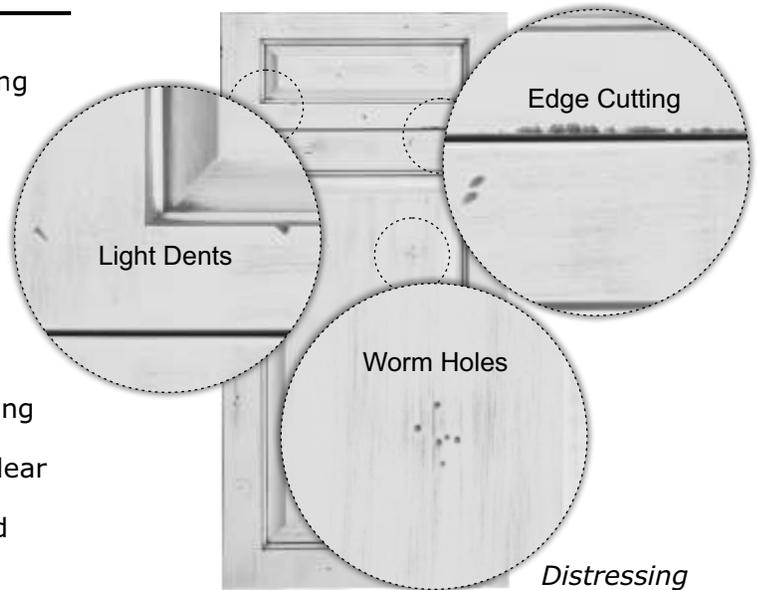


*Antiquing*

**Antiquing** involves some corners getting sanded down, either on the frame or on the raised panel if applicable. We also sand some areas of the inside profiles so they are rounded off to help create a used look. The Antiquing is done prior to staining/painting and also after staining/painting. By doing this sanding after the stain/ paint, it creates a slow transition from a stained/painted product to the raw wood; this then creates a naturally worn look. Antiquing can be used on our stained products and solid color "painted" products. After the Antiquing has been done for the final time the doors are clear coated to preserve the finish and protect any bare wood. The difference between Antiquing and Rub-Through is that Antiquing has more aggressively sanded corners. This creates a more rustic look. (Elias Code = "A")

**Prefinishing Information**

**Distressing** is defined as the process of applying various light dents, light cutting and some randomly placed "worm holes" in the door. This distressed characteristic is applied with custom made tools and is applied randomly to each piece. The distressing also dictates the occasional cutting on the outside edge of the door; this cut is sanded smooth to the touch and adds to the overall "distressed" look. The joints on the door frame may also be cut to emphasize a crack. (This is a non-structural crack, made for appearance only). The distressing is done prior to staining/painting. Once the distressing has been completed the doors are clear coated to preserve their appearance. This distressing can be used on our stained and solid color "painted" products. (Elias Code = "D")



**Distressing/Antiquing** is defined as a combination of Distressing and Antiquing, as per the definitions above, applied to each door. The Distressing/Antiquing process is applied both prior to and after the staining/painting process. By doing this the stain or paint "feathers" off from raw wood to finished product creating a naturally worn and well used look. The product is then clear coated to preserve the look. The Distressing/Antiquing can be used on our stained products and solid color "painted" products. (Elias Code = "DA")



**Samples**

To be sure whether any of these finishes are the right appearance for you or your customer, please order samples before starting a project. You may also view a picture of each technique on our website at [www.eliaswoodwork.com](http://www.eliaswoodwork.com).

Samples of all our products are available upon request. Sample doors are eligible for a 20% sample discount on top of your current discount price. Sample doors will come with identification labels on the back that lists the door details (outside edge, panel profile, etc.) for ease of selling and ordering. Orders for display kitchens or show room displays may be ordered as you would any other order, just let us know that it is a sample for an upcoming project or your showroom. For cabinet door samples we currently stock certain doors and can ship these out in a timely fashion.



Please see the Sample Kit page on our website for a list of stocked sample doors. Any other style and wood type is available; it would need

manufacturing time prior to shipping. For all other samples including molding, drawer boxes, etc., please call your Customer Service Specialist.

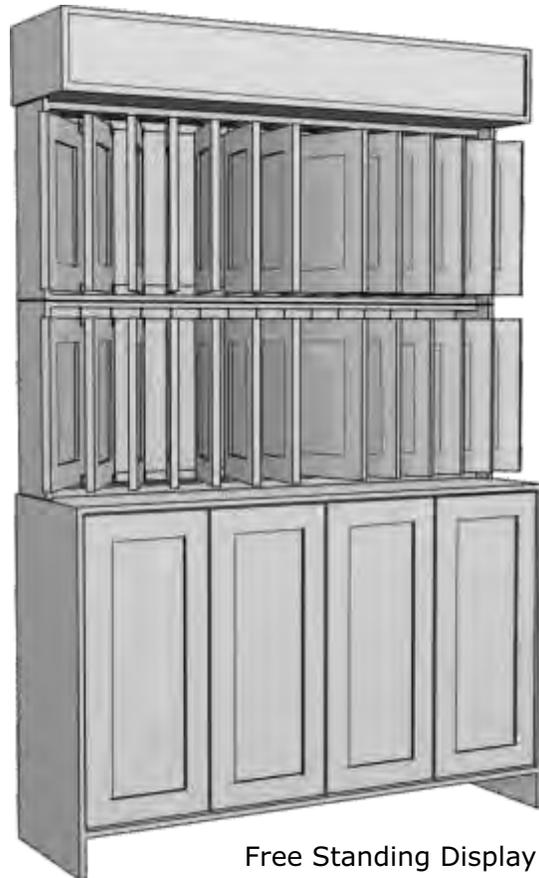
## Sample Kits

We have several dealer aid sample kits available. Each kit contains sample doors, product catalog, marketing catalog and sample color chains for our wood painted & stained, RTF, DLV & Acrylic colors. All product samples and sample chains can be ordered individually or as add-ons to your kit. We also have a carry case available for your customer visits. There is additional marketing material to assist with customer sales and each kit can be customized with your choice of door samples from our stock door list. Call us today for Sample Kit options available, or to order your customized kit.



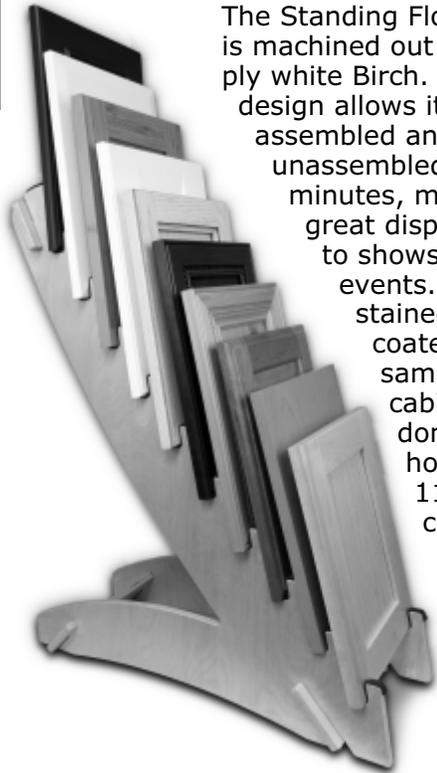
**Displays** For all displays we have preselected the sample doors to show a large range of styles, materials and coating types to make sure you have something for everyone's tastes. If you would like to select the cabinet door styles yourself please indicate the doors you would like to have on your purchase order or talk to your Customer Service Specialist.

The Free Standing Cabinet display holds up to twenty six 11" x 15" cabinet doors that are hinged and can be leafed through similar to pages in a book. The lower portion of the display has working cabinet doors and includes shelving for brochures and other literature. There is space on the top of the display for your company's name and logo. The cabinet is made from Maple plywood that is stained and top coated with the same finishing lines that our cabinet doors go through. The cabinet doors will be machined for the supplied hardware but you will need to fix the brackets to the doors when you receive them.



Free Standing Display - **FSD**

Standing Floor Display - **SFD**



The Standing Floor Display is machined out of a nine ply white Birch. Its unique design allows it to be assembled and unassembled in just minutes, making it a great display to take to shows and events. This stand is stained and top coated with the same process that cabinet doors are done with and holds up to ten 11" x 15" cabinet doors.

Hanging Wall Display - **HWD**



The Hanging Wall Display consists of two aluminum "L" brackets machined to hold fifteen cabinet doors. The kit includes polished chrome hardware that attaches to the cabinet doors and fits in the supplied "L" brackets which will need to be fixed to a wall or mounted to your display unit. The cabinet doors are 11" x 15" in size and will be machined for the supplied hardware but you will need to fix the brackets to the doors when you receive them. There are fifteen cabinet doors included with this display.

Table Top Refacing Display (Top & Bottom) - **TTRD2**  
Cabinet Doors Section ONLY - **TTRD**

Table Top Refacing Before and After display is intended to help you describe the refacing process and give your customers a visual for transforming their existing cabinets from old to new which aids in the selling process. This versatile, light weight display is small enough to be carried and is intended for table top use. It can be utilized in a show room, as a home sales tool or even a trade show display. The display comes with two cabinet doors, a face frame, hinges, door pulls and crown molding.



**NOTES**

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