



**norcraft®**  
**CABINETRY**

# our process to create a fine furniture finish product

## 1. Inspection

Only high quality hardwoods and hardwood veneers are used in making our cabinetry. The first step is inspecting the component parts to insure that they meet these high standards. High quality raw materials are the basis for a fine furniture finish product.

## 2. Prep sanding

All the doors are sanded with a fine grit sandpaper to assure that all parts of the wood will take the finish uniformly and evenly. Prep sanding is essential for cabinets to have a consistent color.

## 3. Cleaning

Each part is cleaned of dust and debris prior to entering the stain booth. The cleaning prevents any unfinished areas from occurring under the top coat.

## 4. Staining/Painting

The penetrating stain or paint is hand applied utilizing processes to make sure that the color is uniformly distributed throughout the product.

## 5. Color inspection

The stained or painted product goes through a color inspection station where it is compared to a color standard to assure that all parts of the kitchen will be uniform in color.

## 6. Drying

The product is then oven dried to assure all parts are fully dry prior to sealing. Proper drying prevents moisture below the finish coat which can cause "bubbling" of the top coat.

## 7. Sealer coat

The seal coat provides a base for the top coat by filling in any open pores in the wood. This sealing allows the top coat to go on uniformly and evenly.

## 8. Drying

The seal coat is oven cured for uniform hardness and drying. This prevents finish problems like crackling and peeling.

## 9. Seal sanding

The parts are lightly touch sanded with a fine grit sandpaper to prevent any raised grain or roughness. This allows for a more uniform build up in the top coat.

## 10. Cleaning

After sanding the parts are cleaned of any debris. This insures no dust is in the top coat.

## 11. Top coat

A self sealing conversion varnish is used for a top coat. This provides exceptional resistance to moisture, chemicals, and scratching.

## 12. Drying

The top coat is oven cured. This chemically locks in the properties of the top coat finalizing the finish quality.

## 13. Inspection

All product goes through a final inspection in the finish area assuring consistent color and finish quality.

## Additional finish steps for Glazed Product

1. After the seal sanding and cleaning the glaze is hand applied.
2. The glazed product is placed on a rack to air dry.
3. The product then goes through the top coat, drying, and inspection steps.

## Glazing over Stain

- The contrasting glaze color hangs up in the profiles of the product. It will also darken the color of the underlying stain color.
- Doors, drawer fronts, and large mouldings are hand glazed
  - This hand application allows for an "artisan" finish meaning that no two doors or drawers will look exactly the same. The amount of hang up will vary on each door.
  - In areas with deep edges, corners or unique wood characteristics, a heavier amount of glaze may collect and remain as removal will be more difficult.
  - Flat and smooth areas are easier to wipe resulting in less hang up on the surface.
- Face frames, veneer end and back panels, and small mouldings get a tinted sealer so that these parts match the doors and drawer fronts.

## Glazing over Paint

- The profiles of doors, drawer fronts, and large mouldings are highlight glazed by hand.
  - This hand application allows for an "artisan" finish meaning that no two doors or drawers will look exactly the same. The amount of hang up will vary on each door.
  - The highlight glazing affects only the areas were the glaze is applied. The rest of the product, frames, end panels, and the center panels of doors, do not change color.

## Characteristics of Glazed Products

- The Glazing process adds an additional contrasting color to the product to give an aged, worn, antique type appearance.
- Glazing will range from an even appearance to varied coverage due to the hand application and how the glaze color hangs up in the profiles of the product.
- The final appearance of each glaze piece will depend upon:
  - Door design
  - Edge profile
  - Wood characteristics
  - Base stain color