



## PRODUCT STANDARDS

### GENERAL

Hines Quality Custom Millwork produces millworks according to Architectural Woodwork Institute (AWI) standards. We have, however, developed several manufacturing procedures that produce similar quality in a more cost effective manner. If a project calls for any specific AWI standard, we will adhere to exacting specifications.

### HINES DOORS

Doors are constructed with stiles and rails joined by mortise and tenons.

The stile faces are one piece and not glued for width unless discussed with customer.

All exterior doors have solid laminated stiles.

The stiles for non-MDF interior doors have either:

1/8 veneer laminated over a stave or structural composite lumber core with two wood edges; or solid laminated stiles.

Hines may offer at a lower price all MDF interior doors made from 1/8 MDF laminated over a MDF core with 1 wood edge.

Doors are sanded with a finish sand of 150 grit for paint grade and 180 grit for stain grade.

Raised wood panels are solid lumber glued for width unless rim banding is specified.

Paint grade doors include MDF panels.

Exterior wood panels are laminated for thickness including a 1/4" cross-banded core and MDF panels are made from an exterior MDF grade.

### MOULDINGS

Hines Quality Custom Millwork carries an inventory of oak and poplar moulding profiles available for immediate delivery. Listings of our stocked items are available on our web site.

Hines Quality Custom Millwork carries a large inventory of standard blank sizes in poplar for manufacturing items for quick deliver. Hines standard moulding sizes are 2 1/2", 3 1/2", 4 1/4", 5 1/4", and 7 1/4" for 4/4 thick blanks. Any Hines profile from blanks of these sizes can be delivered in two weeks or less. Hines manufactures its mouldings based on the Architectural Woodworkers Institute Quality Standards.

Mouldings from nonstandard blank sizes will have an extended delivery time and a potential 10% overrun will be shipped and billed for such mouldings.

If you have a requirement for a moulding not shown in our catalog and would like a quotation, please fax Hines Quality Custom Millwork a drawing with dimensions. Hines Quality Custom Millwork will provide a price for knife tooling, set up charge, and per foot charge. All of these prices are included in the linear foot or piece price. A potential 10% overrun will be shipped and billed for such mouldings. Upon order, please supply a sample if available for an accurate duplication of your custom profile.



## PRODUCT STANDARDS *(continued)*

Unless specified on the orders, all mouldings will be delivered in random lengths that may vary between 4'-16' for casing and 6'-16' for base and 8' to 16' crown dependent on the wood species. Some species are not available in lengths over 9'.

Hines Quality Custom Millwork specializes in buying premium hardwoods from exceptional sources. However, long lengths and wide widths are more difficult to acquire in certain species such as walnut, cherry, select maple, select birch. The longest length available will be shipped and widths greater than 4 1/4" may be glued. The longest lengths available will probably be 9' - 12' dependent on availability.

### PRIMED ITEMS

We stock a group of purchased primed mouldings. Priming is also available for mouldings and doors manufactured by Hines Quality Custom Millwork.

### CUSTOMERS MATERIALS

We will not incorporate customer materials into our manufactured products. This includes but is not limited to glass, hinges, lumber, doors, hardware, etc. If such a situation exists where this may be a necessity, then Hines Quality Custom Millwork must develop an agreement on how these items will be used in advance of any manufacturing or production activity.

### WINDOWS AND ENTRIES

Hines salespeople will provide customers a rough opening for framing openings for windows and entries. If an exterior biswing has a "t" astragal, our standard is not to undersize the passive door. Therefore, the rough opening must be adjusted accordingly by adding 1/2 inch in width.

### INTERIOR PREHUNG

Hines Quality Custom Millwork pre-hangs doors of all sizes and styles from many species. The standard paint grade jamb and stop is poplar jointed primed. Other less expensive jambs such as fjp or paperwrap are also available for multiple unit projects. If an interior biswing has a "t" astragal, our standard is not to undersize the passive door.

### ULTRA FLEX

We stock S4S ultra flex, which can be shaped with an edge profile. All profiled pieces such as casing, base, and crowns have to be ordered from Ultra Flex and thus require a lead-time of at least two to three weeks. If the order is for a profile for which we have not yet purchased the Ultra Flex Mould, lead times increase 2 weeks. If Hines did not make the wood moulding, then we cannot order the mould from Ultra Flex until we have made the sample moulding. Ultra Flex products that require bending in width such as crowns, not in thickness such as casing, require the radius of the finished wall and whether the application is concave or convex.



## PRODUCT STANDARDS *(continued)*

### WOOD RADIUS PRODUCTS

Hines Quality Custom Millwork makes wood radius products utilizing a finger jointing process, which yields a highly accurate part holding true radius dimensions. The joints ensure that for stain products the grain runs correctly throughout the length of the item and become barely detectable after finishing.

Hines uses the same knives to profile a radius piece as used for manufacturing straight mouldings. This enables the radius profile to accurately miter into lineal casings legs on doors or windows.

All radius information such as width, rise, and radius is expressed in terms based on the inside jamb to jamb opening. For shapes with one single radius, this information will allow us to manufacture the correct size. However, shapes with multiple radii such as an ellipse a template must be provided with clean lines marking the inside jamb opening. In some instances for a radius with a single arch, the drawings from a window vendor provide adequate information. However, if this information is an outside jamb radius, subtract the jamb thickness to get the inside opening radius dimension for production. Radius crown applications require a template so as to fit any irregularities in the wall's construction.

#### Radius definitions

Arch	Segment of a circle
Cathedral	Two radii reversed
Half Circle	One radius (1/2 of a width)
Elliptical	Two minor radii, one major radius

### CASED OPENINGS

Jambs wider than 11 ¼, Hines will use MDF for jambs. On radius openings, our standards are solid wood on the head up to 13" and bendable plywood for the head when the jamb is greater than 13". Minimum radiuses apply to certain radiuses at particular jamb widths.

### DOOR MACHINING

Hines Quality Custom Millwork installs hinges based on Hines standard hinge layouts, and sizes as specified in the Stanley Reference Manual. Customers can, however, specify the number and sizes of hinges for any opening although Hines cannot guarantee the applications longevity. Machining for nonstandard hinges such as Soss, Paulelle (H), or Pivot will require additional charges.

Hines Quality Custom Millwork machines for a variety of special locks per the manufacturers standards. Our standard bore height is 36" from bottom of the door regardless of the door design unless the order specifies a different height location. Please note that many door designs do not have the lock rail at 36" on center.

When machining for mortise locks, our standard is to prepare the mortise pocket and edge preparation leaving the face bore to be done on site by others.



## PRODUCT STANDARDS *(continued)*

### INSTALLATION

All products whether manufactured by Hines or supplied by Hines must be installed correctly for any warranties to apply. It is the responsibility of the installer to perform the installation correctly. Please note that our warranty specifies that we do not warranty the other manufacturer's product. We will help customers work with our vendors to insure coverage under the manufacture's warranty.