

# Architectural Doors

In addition to our stock standard flush doors including Red Oak, Birch, Lauan, Prime and hardboard embossed prefinished we offer 5-ply architectural doors which include the following:

- Particle Core (PC)
- Stave Core (SC)
- Structural Composite Lumber Core (SCL)
- 45/60/90 Fire doors with Neutral pressure/Positive Cat A/Positive Cat B
- Lead Line Particle Core
- Lead Line Structural Composite Lumber Core
- Lead Line Structural Composite Lumber Core with thick lead
- Lead Line 45 Minute Core
- Sketch Face and Inlay Doors



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B&B offers an architectural grade flush door in a wide range of veneer faces and veneer flitch in domestic and exotic species. Our manufacturers have the ability to splice veneer flitch into standard or specialty matching faces. Once all the components are staged; the doors are individually hot pressed. Complete factory machining and finishing are available on our products. Our manufacturers uses an environmentally friendly UV cured roll coat line, which meets or exceeds all TR-6 requirements.

Current stock includes 36" wide x 80" & 84" high Plain Sliced Cherry, Plain Sliced White Maple and Plain Sliced Walnut. All other species please allow 3-4 weeks.

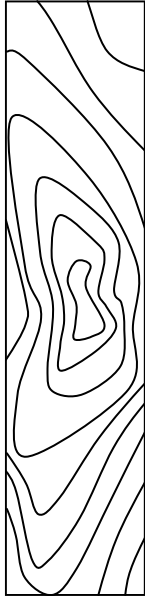
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# Veneer Cuts

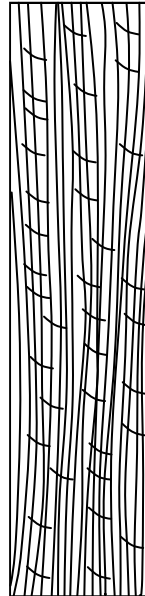
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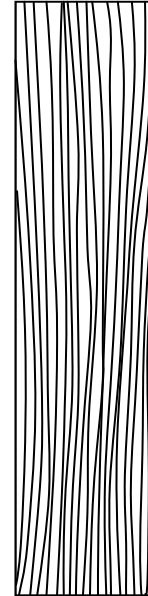
**Rotary Cut**



**Plain Sliced**  
(Flat Cut)



**Quarter Cut:**  
Red & White Oak



**Quarter Cut:**  
Other Species  
**Rift Cut:**  
Red & White Oak

## **Rotary**

This cut follows the log's annual growth rings, providing a general bold random appearance.

## **Plain Sliced**

Slicing is done parallel to a line through the center of the log. Cathedral and straight grained patterns result. The individual pieces of veneer are kept in the order they are sliced, permitting a natural grain progression when assembled as veneer faces.

## **Quartered**

This cut is in a radial direction to the pith to achieve a straight grain pattern. In Red & White Oak ray fleck is produced and the amount may be unlimited.

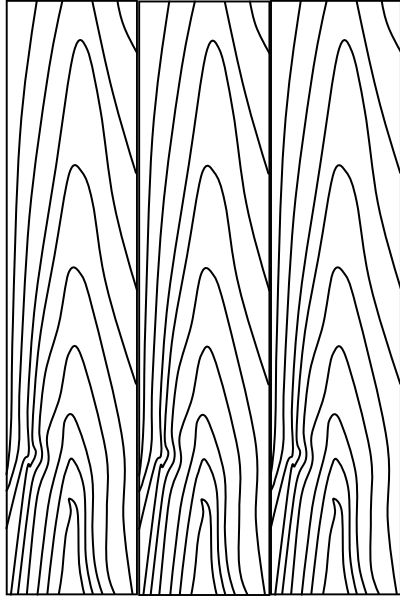
## **Rift**

This cut is at a slight angle to the radial to produce a quartered appearance without excessive ray fleck. Rift is only available in Red and White Oak.

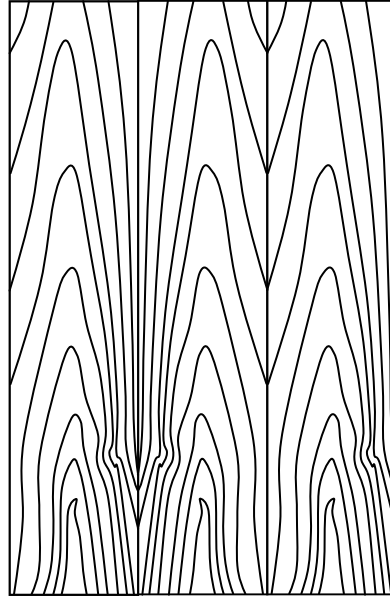


# Veneer Matching Between Pieces

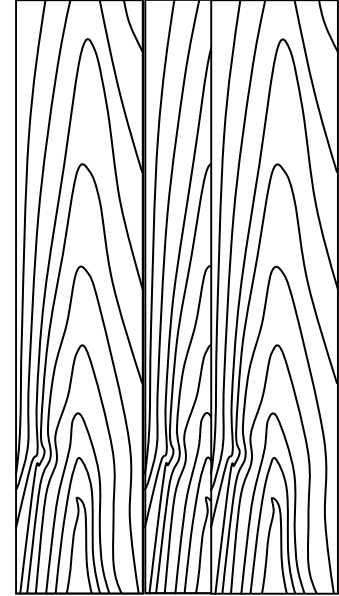
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Slip Match



Book Match



Random Match

## Slip Match

Adjoining pieces of veneer are placed in sequence without turning over every other piece. The grain figure repeats, but joints won't show mirrored effect. Slip matching is recommended and often used in quarter and rift cut veneers to eliminate the barber pole effect. However, it may cause a sloping appearance of the veneer.

## Book Match

The most commonly used match in the industry. Every other piece of veneer is turned over so adjacent pieces are like two adjacent pages in an open book. The veneer joints match and create a mirrored image at the joint line, yielding maximum continuity of grain. Because the "tight" and "loose" faces alternate in adjacent pieces of veneer they may accept stain or reflect light differently, and this may yield a noticeable color variation called **Barber Poling**. Barber pole is not considered a manufacturing defect.

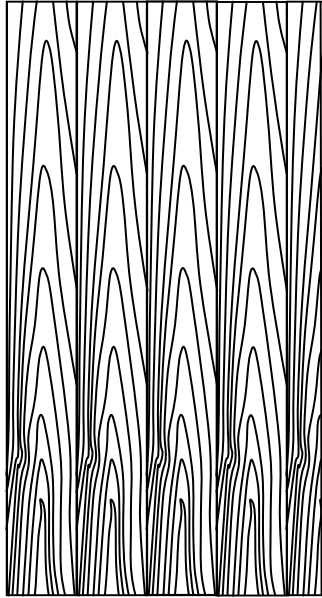
## Random Match

A face containing veneer strips of the same species which are selected and assembled without regard to color or grain, resulting in variations and contrasts in color and grain.

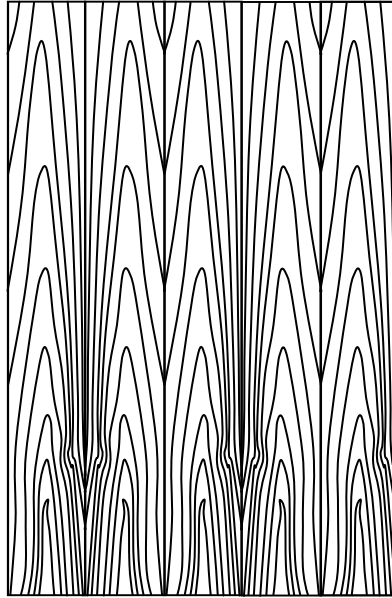


# Veneer Matching on Door Face

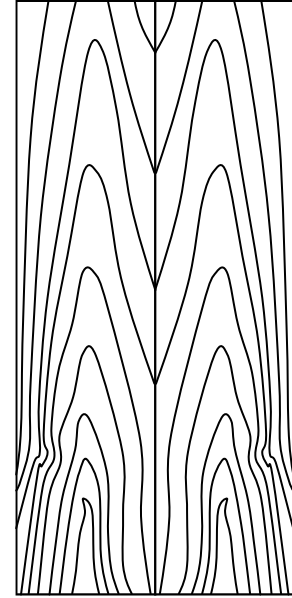
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**Running Match**



**Balance Match**



**Center Balance Match**

## **Running Match**

A non-symmetrical appearance in any single door face where side edge pieces of veneer are of unequal width. Each face is assembled from as many veneer pieces as necessary.

**Veneer Yield:** High

## **Balance Match**

A symmetrical appearance where each face is assembled from pieces of uniform width before trimming.

**Veneer Yield:** Medium

## **Center Balance Match**


A symmetrical appearance where each face has an even number of veneer pieces of uniform width before trimming. Thus, there is a veneer joint in the center of the face, producing symmetry

**Veneer Yield:** Low



# Rotary Red Oak


Color and Matching		
Cut	Rotary	Rotary
Grade	AA	A
Sapwood	No	5%
Heartwood	Yes	Yes
Color Streaks	Yes	Yes
Color Variation	Slight	Slight
Sharp Color Contrasts at Joints	Yes if Slip Matched	Yes if Slip Matched
Matching		
Book Matched	Yes	Yes
Slip Matched	Specify	Specify
Flitch Width	5 in.	4 in.
Natural Characteristics		
Small Burls/Pin Knots	1 per 4 sq.ft.	1 per 2 2/3 sq.ft.
Burls Size	1/4 in.	3/8 in.
Conspicuous Pin Knots	XXXXXXXXXXXX	XXXXXXXXXXXX
Avg Number	No	1 per 3 sq. ft.
Size - Dark Part	No	1/8 in.
Size - Total	No	1/4 in.
Mineral Streaks	No	Slight, Blending
Bark Pockets	No	No
Worm Tracks	No	No
Vine Marks	No	Slight
Cross Bars	Slight	Slight
Manufacturing Characteristics		
Rough Cut	No	No
Hairline Splits	2- 1/32 in. x 3 in.	2- 1/16 in. x 6 in.
Blending Repairs	Very Small	Small
Special Characteristics		




# Plain Sliced Red Oak

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Color and Matching		
Cut	Plain Sliced	Plain Sliced
Grade	AA	A
Sapwood	No	No
Heartwood	Yes	Yes
Color Streaks	Yes	Yes
Color Variation	Slight	Slight
Sharp Color Contrasts at Joints	Yes if Slip Matched	Yes if Slip Matched
Matching		
Book Matched	Yes	Yes
Slip Matched	Specify	Specify
Flitch Width	5 in.	4 in.
Natural Characteristics		
Small Burls/Pin Knots	1 per 4 sq.ft.	1 per 2 2/3 sq.ft.
Burls Size	1/4 in.	3/8 in.
Conspicuous Pin Knots	XXXXXXXXXXXX	XXXXXXXXXXXX
Avg Number	No	1 per 3 sq. ft.
Size - Dark Part	No	1/8 in.
Size - Total	No	1/4 in.
Mineral Streaks	No	Slight, Blending
Bark Pockets	No	No
Worm Tracks	No	No
Vine Marks	No	Slight
Cross Bars	Slight	Slight
Manufacturing Characteristics		
Rough Cut	No	No
Hairline Splits	2- 1/32 in. x 3 in.	2- 1/16 in. x 6 in.
Blending Repairs	Very Small	Small
Special Characteristics		




# Rift Red Oak


Color and Matching		
Cut	Rift	Rift
Grade	AA	A
Sapwood	No	No
Heartwood	Yes	Yes
Color Streaks	Yes	Yes
Color Variation	Slight	Slight
Sharp Color Contrasts at Joints	Yes if Slip Matched	Yes if Slip Matched
Matching		
Book Matched	Yes	Yes
Slip Matched	Specify	Specify
Flitch Width	3 in.	3 in.
Natural Characteristics		
Small Burls/Pin Knots	1 per 4 sq.ft.	1 per 2 2/3 sq.ft.
Burls Size	1/4 in.	3/8 in.
Conspicuous Pin Knots	XXXXXXXXXXXX	XXXXXXXXXXXX
Avg Number	No	1 per 3 sq. ft.
Size - Dark Part	No	1/8 in.
Size - Total	No	1/4 in.
Mineral Streaks	No	Slight, Blending
Bark Pockets	No	No
Worm Tracks	No	No
Vine Marks	No	Slight
Cross Bars	Slight	Slight
Manufacturing Characteristics		
Rough Cut	No	No
Hairline Splits	2- 1/32 in. x 3 in.	2- 1/16 in. x 6 in.
Blending Repairs	Very Small	Small
Special Characteristics		
Ray Fleck (Flake) is not to exceed 3/8 in. in width		
Slope - 1" in 12" max. grain slope		
Sweep - 2 1/2" in 12" max. grain sweep		





# Plain Sliced White Oak

Color and Matching		
Cut	Plain Sliced	Plain Sliced
Grade	AA	A
Sapwood	No	No
Heartwood	Yes	Yes
Color Streaks	Yes	Yes
Color Variation	Slight	Slight
Sharp Color Contrasts at Joints	Yes if Slip Matched	Yes if Slip Matched
Matching		
Book Matched	Yes	Yes
Slip Matched	Specify	Specify
Flitch Width	5 in.	4 in.
Natural Characteristics		
Small Burls/Pin Knots	1 per 4 sq.ft.	1 per 2 2/3 sq.ft.
Burls Size	1/4 in.	3/8 in.
Conspicuous Pin Knots	XXXXXXXXXXXX	XXXXXXXXXXXX
Avg Number	No	1 per 3 sq. ft.
Size - Dark Part	No	1/8 in.
Size - Total	No	1/4 in.
Mineral Streaks	No	Slight, Blending
Bark Pockets	No	No
Worm Tracks	No	No
Vine Marks	No	Slight
Cross Bars	Slight	Slight
Manufacturing Characteristics		
Rough Cut	No	No
Hairline Splits	2- 1/32 in. x 3 in.	2- 1/16 in. x 6 in.
Blending Repairs	Very Small	Small
Special Characteristics		




# Rotary Natural Birch

Color and Matching		
Cut	Rotary	Rotary
Grade	AA	A
Sapwood	Yes	Yes
Heartwood	Yes	Yes
Color Streaks	Slight	Yes
Color Variation	Yes	Yes
Sharp Color Contrasts at Joints	Yes if Slip Matched	Yes if Slip Matched
Matching		
Book Matched	Yes	Yes
Slip Matched	Specify	Specify
Flitch Width	5 in.	4 in.
Natural Characteristics		
Small Burls/Pin Knots	1 per 5 sq.ft.	1 per 3 sq.ft.
Burls Size	1/4 in.	3/8 in.
Conspicuous Pin Knots	XXXXXXXXXXXX	XXXXXXXXXXXX
Avg Number	No	1 per 8 sq. ft.
Size - Dark Part	No	1/8 in.
Size - Total	No	1/4 in.
Mineral Streaks	Slight	Slight
Bark Pockets	No	No
Worm Tracks	Slight	Slight
Vine Marks	Slight	Slight
Cross Bars	Slight	Slight
Manufacturing Characteristics		
Rough Cut	No	No
Hairline Splits	2- 1/32 in. x 3 in.	2- 1/16 in. x 6 in.
Blending Repairs	Very Small	Small
Special Characteristics		
Note: When specifying Natural, veneers contain unlimited amounts of sapwood and/or heartwood		



# Plain Sliced Natural Birch

Color and Matching		
Cut	Plain Sliced	Plain Sliced
Grade	AA	A
Sapwood	Yes	Yes
Heartwood	Yes	Yes
Color Streaks	Slight	Yes
Color Variation	Yes	Yes
Sharp Color Contrasts at Joints	Yes if Slip Matched	Yes if Slip Matched
Matching		
Book Matched	Yes	Yes
Slip Matched	Specify	Specify
Flitch Width	5 in.	4 in.
Natural Characteristics		
Small Burls/Pin Knots	1 per 5 sq.ft.	1 per 3 sq.ft.
Burls Size	1/4 in.	3/8 in.
Conspicuous Pin Knots	XXXXXXXXXXXX	XXXXXXXXXXXX
Avg Number	No	1 per 8 sq. ft.
Size - Dark Part	No	1/8 in.
Size - Total	No	1/4 in.
Mineral Streaks	Slight	Slight
Bark Pockets	No	No
Worm Tracks	Slight	Slight
Vine Marks	Slight	Slight
Cross Bars	Slight	Slight
Manufacturing Characteristics		
Rough Cut	No	No
Hairline Splits	2- 1/32 in. x 3 in.	2- 1/16 in. x 6 in.
Blending Repairs	Very Small	Small
Special Characteristics		
Note: When specifying Natural, veneers contain unlimited amounts of sapwood and/or heartwood		




# Rotary White Birch

Color and Matching		
Cut	Rotary	Rotary
Grade	AA	A
Sapwood	Yes	Yes
Heartwood	No	No
Color Streaks	Slight	Slight
Color Variation	Slight	Slight
Sharp Color Contrasts at Joints	Yes if Slip Matched	Yes if Slip Matched
Matching		
Book Matched	Yes	Yes
Slip Matched	Specify	Specify
Flitch Width	5 in.	4 in.
Natural Characteristics		
Small Burls/Pin Knots	1 per 5 sq.ft.	1 per 3 sq.ft.
Burls Size	1/4 in.	3/8 in.
Conspicuous Pin Knots	XXXXXXXXXXXX	XXXXXXXXXXXX
Avg Number	No	1 per 8 sq. ft.
Size - Dark Part	No	1/8 in.
Size - Total	No	1/4 in.
Mineral Streaks	No	Slight
Bark Pockets	No	No
Worm Tracks	Slight	Slight
Vine Marks	Slight	Slight
Cross Bars	Slight	Slight
Manufacturing Characteristics		
Rough Cut	No	No
Hairline Splits	2- 1/32 in. x 3 in.	2- 1/16 in. x 6 in.
Blending Repairs	Very Small	Small
Special Characteristics		



# Plain Sliced White Birch

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Color and Matching		
Cut	Plain Sliced	Plain Sliced
Grade	AA	A
Sapwood	Yes	Yes
Heartwood	No	No
Color Streaks	Slight	Slight
Color Variation	Slight	Slight
Sharp Color Contrasts at Joints	Yes if Slip Matched	Yes if Slip Matched
Matching		
Book Matched	Yes	Yes
Slip Matched	Specify	Specify
Flitch Width	5 in.	4 in.
Natural Characteristics		
Small Burls/Pin Knots	1 per 5 sq.ft.	1 per 3 sq.ft.
Burls Size	1/4 in.	3/8 in.
Conspicuous Pin Knots	XXXXXXXXXXXX	XXXXXXXXXXXX
Avg Number	No	1 per 8 sq. ft.
Size - Dark Part	No	1/8 in.
Size - Total	No	1/4 in.
Mineral Streaks	No	Slight
Bark Pockets	No	No
Worm Tracks	Slight	Slight
Vine Marks	Slight	Slight
Cross Bars	Slight	Slight
Manufacturing Characteristics		
Rough Cut	No	No
Hairline Splits	2- 1/32 in. x 3 in.	2- 1/16 in. x 6 in.
Blending Repairs	Very Small	Small
Special Characteristics		




# Plain Sliced White Maple

Color and Matching		
Cut	Plain Sliced	Plain Sliced
Grade	AA	A
Sapwood	Yes	Yes
Heartwood	No	No
Color Streaks	Slight	Slight
Color Variation	Slight	Slight
Sharp Color Contrasts at Joints	Yes if Slip Matched	Yes if Slip Matched
Matching		
Book Matched	Yes	Yes
Slip Matched	Specify	Specify
Flitch Width	5 in.	4 in.
Natural Characteristics		
Small Burls/Pin Knots	1 per 5 sq.ft.	1 per 3 sq.ft.
Burls Size	1/4 in.	3/8 in.
Conspicuous Pin Knots	XXXXXXXXXXXX	XXXXXXXXXXXX
Avg Number	No	1 per 8 sq. ft.
Size - Dark Part	No	1/8 in.
Size - Total	No	1/4 in.
Mineral Streaks	Slight	Slight
Bark Pockets	No	No
Worm Tracks	Slight	Slight
Vine Marks	Slight	Slight
Cross Bars	Slight	Slight
Manufacturing Characteristics		
Rough Cut	No	No
Hairline Splits	2- 1/32 in. x 3 in.	2- 1/16 in. x 6 in.
Blending Repairs	Very Small	Small
Special Characteristics		




# Flat Cut African Mahogany

Color and Matching		
Cut	Flat Cut	Flat Cut
Grade	AA	A
Sapwood	No	No
Heartwood	Yes	Yes
Color Streaks	Slight	Slight
Color Variation	Slight	Slight
Sharp Color Contrasts at Joints	Yes if Slip Matched	Yes if Slip Matched
Matching		
Book Matched	Yes	Yes
Slip Matched	Specify	Specify
Flitch Width	5 in.	4 in.
Natural Characteristics		
Small Burls/Pin Knots	1 per 5 sq.ft.	1 per 3 sq.ft.
Burls Size	1/4 in.	3/8 in.
Conspicuous Pin Knots	XXXXXXXXXXXX	XXXXXXXXXXXX
Avg Number	No	1 per 8 sq. ft.
Size - Dark Part	No	1/8 in.
Size - Total	No	1/4 in.
Mineral Streaks	No	Slight
Bark Pockets	No	No
Worm Tracks	No	No
Vine Marks	Slight	Slight
Cross Bars	Occasional	Occasional
Manufacturing Characteristics		
Rough Cut	No	No
Hairline Splits	2- 1/32 in. x 3 in.	2- 1/16 in. x 6 in.
Blending Repairs	Very Small	Small
Special Characteristics		




# Plain Sliced Cherry

Color and Matching		
Cut	Plain Sliced	Plain Sliced
Grade	AA	A
Sapwood	No	No
Heartwood	Yes	Yes
Color Streaks	Slight	Slight
Color Variation	Slight	Slight
Sharp Color Contrasts at Joints	Yes if Slip Matched	Yes if Slip Matched
Matching		
Book Matched	Yes	Yes
Slip Matched	Specify	Specify
Flitch Width	5 in.	4 in.
Natural Characteristics		
Small Burls/Pin Knots	1 per 4 sq.ft.	1 per 1 1/3 sq.ft.
Burls Size	1/4 in.	3/8 in.
Conspicuous Pin Knots	XXXXXXXXXXXX	XXXXXXXXXXXX
Avg Number	1 per 5 sq. ft.	1 per 2 sq. ft.
Size - Dark Part	1/8 in.	1/8 in.
Size - Total	1/4 in.	1/4 in.
Mineral Streaks	Slight	Slight
Bark Pockets	No	No
Worm Tracks	No	No
Vine Marks	Slight	Occasional
Cross Bars	Slight	Occasional
Manufacturing Characteristics		
Rough Cut	No	No
Hairline Splits	2- 1/32 in. x 3 in.	2- 1/16 in. x 6 in.
Blending Repairs	Very Small	Small
Special Characteristics		
Gum Spots - Occasional gum spots permitted in Cherry		






# Plain Sliced Walnut

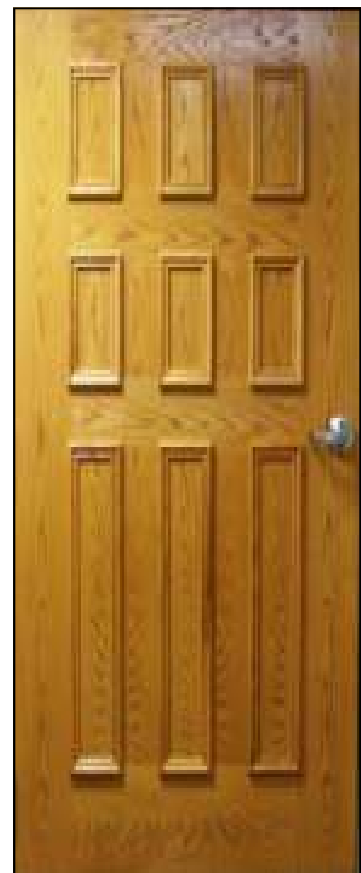
Color and Matching		
Cut	Plain Sliced	Plain Sliced
Grade	AA	A
Sapwood	No	No
Heartwood	Yes	Yes
Color Streaks	Slight	Slight
Color Variation	Slight	Slight
Sharp Color Contrasts at Joints	Yes if Slip Matched	Yes if Slip Matched
Matching		
Book Matched	Yes	Yes
Slip Matched	Specify	Specify
Flitch Width	5 in.	4 in.
Natural Characteristics		
Small Burls/Pin Knots	1 per 4 sq.ft.	1 per 1 1/3 sq.ft.
Burls Size	1/4 in.	3/8 in.
Conspicuous Pin Knots	XXXXXXXXXXXX	XXXXXXXXXXXX
Avg Number	1 per 5 sq. ft.	1 per 2 sq. ft.
Size - Dark Part	1/8 in.	1/8 in.
Size - Total	1/4 in.	1/4 in.
Mineral Streaks	Slight	Slight
Bark Pockets	No	No
Worm Tracks	No	No
Vine Marks	Slight	Occasional
Cross Bars	Slight	Occasional
Manufacturing Characteristics		
Rough Cut	No	No
Hairline Splits	2- 1/32 in. x 3 in.	2- 1/16 in. x 6 in.
Blending Repairs	Very Small	Small
Special Characteristics		




# *Specialty Veneers*

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Our manufacturer's doors can be made with any veneer imaginable. Domestic, exotic, hardwood, softwood, and reconstituted veneers are available on our doors or conference room tables. A large amount of veneer flitch is kept in inventory for the ability to splice veneer faces internally. The ability to splice veneer internally shortens the leadtime and reduces cost.



# Finishing Performance

Factory pre-finished doors use a UV cured roll coat finish system that meets or exceeds TR-6 requirements. This is the latest in finishing technology and provides a more durable finish than past systems. The finish material used in the roll coat process is water based and environmentally friendly with minimal material waste. To obtain the color profile required on the project, doors can be finished clear, stained a standard color, or custom matched by our Certified Color Matching Specialists. The UV curing process allows variable gloss levels for a muted, satin, or high gloss appearance. Once the doors reach the end of the UV line they are cured and ready to be packaged and shipped.

UV Cured Roll Coat System	
Test/Chemical	TR-6
Wear Index	5
Cold Check	5
Adhesion	5
Vinegar	5
Lemon Juice	5
Orange Juice	5
Coffee	5
Olive Oil	5
Boiling Water	5
Ammonia	5
Isopropyl Alcohol	5
Wine	5
33% Sulfuric Acid	5
28% Ammonium Hydroxide	5
Gasoline	5
Soap Detergent	5
5=Excellent 3=Good 1=Poor	



# Field Finishing

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Doors should not be considered ready for finishing when initially received. The finisher must thoroughly sand the faces and edges of door. This should be done with the door in a horizontal position with 120, 150, or 180 grit sandpaper. Final sanding should be with 180 grit sand paper. This process is necessary in order to remove all scuffs, handling marks, scratches, raised grain, burnishes, and effects of exposure to moisture. After sanding, all wood dust must be removed and surfaces inspected for any remaining blemishes before finishing. Repeat sanding process if any remaining marks are detected. It is not unusual for this to be a 20 to 30 minute process.

Wood is hygroscopic and dimensionally influenced by changes in moisture content caused by changes within its surrounding environment. To assure uniform moisture exposure and dimensional control, all surfaces must be finished equally. Certain species of wood, particularly oak, may contain extractives which react unfavorably with foreign materials in the finishing system. Do not use steel wool on bare wood, rusty containers or any other contaminate in the finishing system.

A thinned coat of sanding sealer should be applied prior to staining to promote a uniform appearance and avoid sharp contrasts in color or blotchy appearance. Door manufacturers are not responsible for the final appearance of field-finished doors. It is expected that the painting contractor will make adjustments as needed to achieve desired results. All exposed, unfinished wood surfaces should be finished and the top and bottom rails sealed. Cutouts for hardware in doors located adjacent to areas, where high moisture is expected, should be sealed prior to installation of hardware. Dark color finishes should be avoided on all surfaces if the door is exposed to direct sunlight, to reduce the chance of warping or veneer checking.

Water based coatings on unfinished wood may cause veneer splits, highlight joints and raise wood grain. If used on exterior doors, the coating should be an exterior grade product. When installed in exterior applications, doors must be properly sealed and adequately protected from the elements.

All doors must be visually inspected for face grade, color, match or other visible defects prior to finishing or installation.

# Storage & Handling

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- Doors should be stored flat in a dry, well ventilated building
- Do not allow to come in contact with water
- Keep doors 4" off the floor with a protective covering under the bottom door and over the top door
- Avoid exposure to direct sunlight
- Do not subject doors to extreme heat, cold and/or humidity
- HVAC systems should be operating and balanced in the building where doors are being stored
- Do not install doors in building that have wet plaster or cement
- Always handle doors with clean dry hands or while wearing clean dry gloves
- Do not drag doors across one another, they should be lifted and carried when being moved

