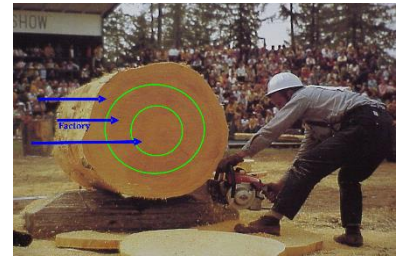


NLGA Door Stock – Lesson 7

I. Clear Zone Utilization:

- a) For Factory and Shop lumber, including Door Stock.
- b) Valued for percentage of cuttings for doors and sash frames.



II. NLGA Door Stock:

- Found in paragraphs 156-158, pages 142-145.
- Grades based on quality and percentage of cuttings.
- Color-coded turquoise for reference.

[illegible]

III. Grading Purpose:

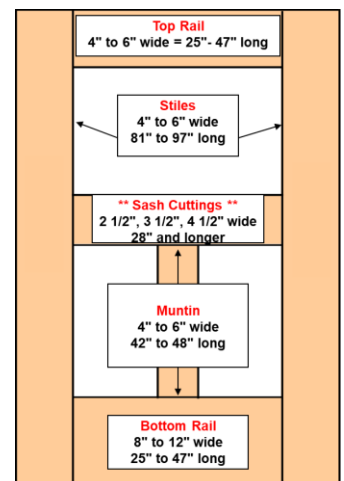
- a) For cutting qualities, usually vertical grain.
- b) Covers all species, focusing on 2-inch size classification.
- c) Graded from the poorest face.

IV. Grades of Door Stock:

- a) Factory Select, Number One Shop, Number Two Shop, Number Three Shop.

V. Cutting Names:

- Stiles, Top Rails, Bottom Rails, Muntins, Lock Rails (not included in classes).
- Panels made of glass, plywood, clear lumber, or one-inch shop.
- Sash cuttings for windows, permissible in Number Three Shop.



VI. Cutting Sizes:

- a) Limits conform to NLGA Rules, paragraph 156-b.
- b) Measured in whole inch increments, excluding one inch around knots.

VII. Cutting Grades:

- a) **Number One Cuttings:** 1 small pocket, 8 rings per inch, slope ≤ 1 in 8.
- b) **Number Two Cuttings:** 6 rings per inch, slope ≤ 1 in 8, firm-stained wood, 1 small pocket, seasoning checks, light torn grain, pitch streaks.
- c) **Number Three Cuttings:** Any rate of growth, any slope, stained wood, 6-inch pocket, seasoning checks, medium pitch streaks, light torn grain, 1 knot $\leq 5/8$ -inch, pin holes.

VIII. Door Stock Grades:

- a) **Factory Select:** $\geq 70\%$ Number One Door Cuttings.
 - I. 4–6-inch widths: Any Number One stiles, 1 Number One Top Rail.
 - II. 8–12-inch widths: Any Number One stiles/bottom rails, 1 Number One Top Rail, 1 Number Two stile if needed.
 - III. No muntins.
- b) **Number One Shop:** 50–70% door cuttings.
 - i. 4–6-inch widths: Any Number One stiles/bottom rails, 2 Number One muntins/top rails, 1 Number Two stile, must contain at least 1 stile.
- c) **Number Two Shop:** $\geq 25\%$ Number One, 40% Number Two, 60% Number Three, or $33\frac{1}{3}\%$ combined Number One and Number Two cuttings. No stile requirement.
- d) **Number Three Shop:** No stile requirement admits pieces below Number Two Shop, 10% mixed door cuttings, 30% mixed sash cuttings, 50% sash cuttings, or 40% Number Three cuttings.

IX. Initial Steps:

- a) Turn the piece to the poorest side.
- b) Check both faces to avoid wane and knots.
- c) Consider narrow faces for knots.

X. Stile Requirement:

- a) Factory Select and Number One Shop require a stile.
- b) Stile lengths: 81 to 97 inches.

XI. If No Stile:

- a) Look for Muntin (42 to 48 inches).

- b) Number Two Shop requires 25% recovery.
- c) One 42-inch Muntin yields 25% recovery of a 14-foot piece.

XII. If No Muntin:

- a) Look for Top Rails (25 to 47 inches).
- b) Number Two Shop counts Number One quality top rails as Number-Two quality (40% recovery needed).

XIII. If Less Than Number Two Shop:

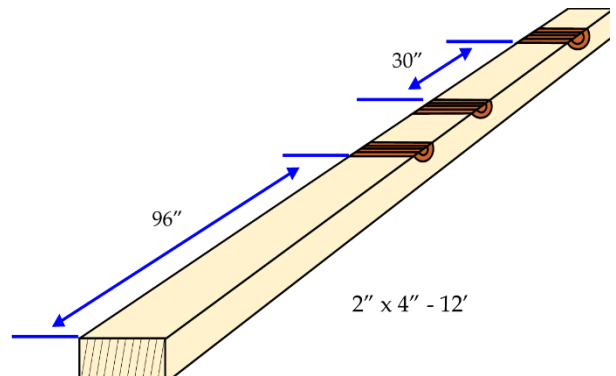
- a) Look for Sash cuttings.
- b) Number Three Shop requires 50% recovery as Sash cuttings.

XIV. Measurement Protocol:

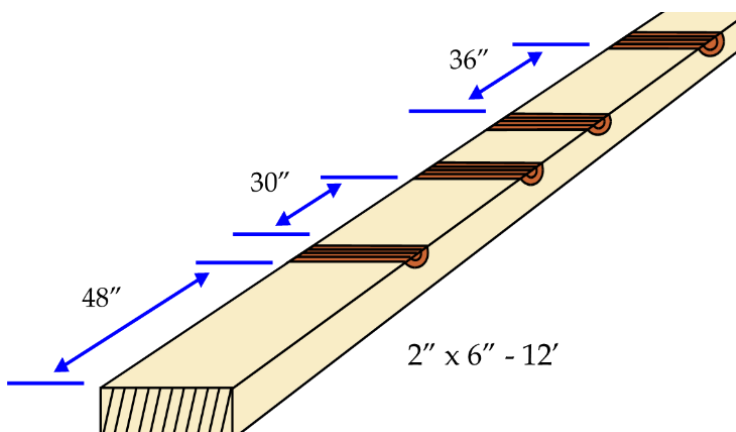
- a) Stay one inch away from knots.
- b) Measure right up to other characteristics.

XV. Example 1:

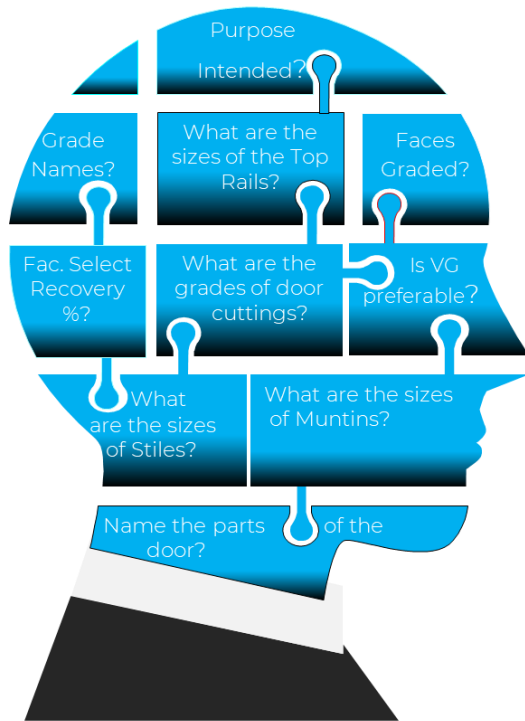
- a) Piece: 4 to 6 inches wide.
- b) Valid cuttings: 96-inch stile, 30-inch top rail.
- c) Recovery: 66% (Number One Shop), 87% (Factory Select with top rail).



XVI. Example 2:



- a) Piece: 4 to 6 inches wide.
- b) No 81-inch stile found.
- c) Valid cutting: 48-inch Muntin (33% recovery).
- d) Additional cuttings: Two top rails (30 and 36 inches).
- e) Grade: Number Two Shop.



NLGA Door Stock Review

Some Thought-Provoking Concepts

- 1 Factory Select % Recovery?
70%
- 2 Grade Names?
Factory Select, #1 Shop, #2 Shop, and #3 Shop
- 3 Faces Graded?
Poorest face
- 4 What are the sizes of the Top Rails?
4" to 6" wide
25" to 47" long
- 5 Purpose Intended?
Cutting Qualities
- 6 What are the grades of the door cuttings?
#1, #2, and #3 cuttings
- 7 Door Stock is preferably sawn VG, True or False?
True
- 8 What are the sizes of Stiles?
4" to 6" wide
81" to 97" long
- 9 What are the sizes of Muntins?
4" to 6" wide
42" to 48" long
- 10 Name the different parts of a door?
Stiles, Top Rails, Bottom Rails, Muntins, Lock Rails, and Panels