



COMMERCIAL AND ARCHITECTURAL
DOOR MANUFACTURER

GLOSSARY

– B –

- Barber Pole** An effect in book matching of veneers resulting from tight and loose sides of veneers having different light reflections when finished.
- Bark Pocket** Comparatively small area of bark around which normal wood has grown.
- Bevel** A machine angle other than a right angle, i.e., a 3 degree bevel which is equivalent to a 1/8 inch drop in a 2 inch span (1 mm in 16 mm).
- Beveled Edge** An edge of the door which forms an angle of less than 90 degrees with the face of the door, such as a 3 degree beveled edge.
- Bird Peck** A mark or wound in a tree or piece of wood caused by birds pecking on the growing tree in search of insects. Also, wood containing such marks.
- Blister** Spot or area where veneer does not adhere.
- Book Size** The height and width of a door prior to prefitting.
- Brashness** Condition of wood characterized by a low resistance to shock and by abrupt failure across the grain without splintering.
- Bullet Resistant Doors** Doors which resist penetration by shots of varying caliber. Resistance may be rated as resistant to medium power, high power or super power small arms and high power rifles.
- Burl** A swirl, twist or distortion in the grain of the wood which usually occurs near a knot or crotch. A burl can often be associated with abrupt color variation and/or a cluster of adventitious buds.
- Burl, Bending** A swirl, twist or distortion in the grain of the wood which usually occurs near a knot or crotch but does not contain a knot and does not contain abrupt color variation. A bending burl is detectable at 6 ft. to 8 ft. (1.8 m to 2.4 m) as a swirl or rounded.
- Butt Joint** A joint formed by square edge surfaces (ends, edges, and faces) coming together; end butt joint, edge butt joint.

– C –

- Chalk** White or other color chalk marks used by the mills for some form of identification to the mill or for making defects for repair.
- Chatter** Line appearing across the face at right angles to the grain giving the appearance of one or more corrugations resulting from bad setting of sanding equipment.
- Clustered** When a defect described in the grading rule is sufficient in number and sufficiently close together to appear to be concentrated in one area.
- Comb Grain** Restricted to red and white oak. This is a rift cut veneer distinguished by the tightness and straightness of the grain along the entire length of the veneer. Slight angle in the grain is allowed. There are occasional cross bars and minimal ray fleck (flake). Availability is limited.
- Compatible Edge Band (CE)** When relating door edge to face appearance the edge may not be the same species as the face, however, it may be similar in overall color, grain, character and contrast as the face (See Matching Edge Band ME).
- Composition Face Panels** A door face panel composed of a wood derivative.
- Core (Hollow)** A core assembly of strips or other units of wood, wood derivative, or insulation board with intervening hollow cells or spaces which support the outer faces. Typical constructions are as follows: Mesh or Cellular A hollow core composed of strips of wood, wood derivative or insulation board, interlocked and running horizontally, vertically or diagonally throughout the core area with air cells and/or spaces between the strips and supporting the outer faces.
- Core (Mineral)** A fire resistant core material generally used in wood doors requiring fire ratings of _ hour or more.

Core (Solid)	The innermost layer or section in flush door construction. Typical constructions are as follows: Particleboard A solid core of wood or other lignocellulose particles bonded together with a suitable binder, cured under heat and process into a rigid panel in a flat platen press. Stave A solid core of wood blocks or strips. Structural Composite Lumber Engineered composite wood products meeting the minimum requirements of ANSI/WDMA. Wood Block, Lined A solid core of two parts; a central wood block core bonded to two core liners of wood or other lignocellulose materials.
Cross Bar	Irregularity of grain resembling a dip in the grain running at right angles, or nearly so, to the length of the veneer.
Cross Break	Separation (break) of the wood cells across the grain. Such breaks may be due to internal strains resulting from unequal longitudinal shrinkage, or the external forces.
Crossbanding	A ply placed between the core and face veneer in 5-ply construction or a ply placed between the back and face of a 3-ply skin in 7-ply construction.
— D —	
Dead Knots (Open Knots)	Openings where a portion of the wood substance of the knot has dropped out or where cross checks have occurred to present an opening.
Decay	The decomposition of wood substance by fungi.
Delamination	Separation of piles or layers of wood or other material through failure of the adhesive bond.
Discolorations	Stains in wood substances. Some common veneer stains are sap stains, blue stains, stain produced by chemical action caused by the iron in the cutting knife coming into contact with the tannic acid in the wood, and those resulting from the chemical action of the glue.
Doze	A form of incipient decay characterized by a dull and lifeless appearance of the wood, accompanied by a lack of strength and softening of the wood.
— E —	
Edge Band	A strip along the outside edges of the two sides and/or top and bottom of the door (See stiles/vertical edges). High Pressure Decorative Laminate Edge Band A separate strip of high pressure decorative laminate may be applied to the edges of the stile or rail.
End Match	A single piece of veneer extends from the bottom to the top of the door with a mirror image at the transom.
— F —	
Face Veneer	The outermost exposed wood veneer surface of a veneered wood door.
Fill (Putty Repairs)	A repair to an open defect, usually made with fast drying plastic putty. Should be well made with non-shrinking putty of a color matching the surrounding area of the wood. To be flat and level with the face and panel, and to be sanded after application and drying.
Finger Joint	A series of interlocking fingers precision cut on the ends of two pieces of wood which mesh together and are held rigidly in place with adhesive.
Fire rated Doors	A door which has been constructed in such a manner that when installed in an assembly and tested will pass ASTM E-152 "Fire Test of Door Assemblies", and can be rated as resisting fire for 20 minutes (1/3 hour), 30 minutes (1/2 hour), 45 minutes (3/4 hour) (C), 1 hour (B), or 1-1/2 hours (B). The door must be tested and carry an identifying label from a qualified testing and inspection agency.
Flake	See Fleck, Ray.
Fleck, Ray	Portion of a ray as it appears on the quartered surface. Fleck can have a dominant appearance feature in oak and is sometimes referred to as flake.
— G —	
Gaps	Open slits in the inner ply or plies or improperly joined veneer when joined veneers are used for inner plies.
Grain	The direction, size, arrangement and appearance of the fibers in wood or veneer.
Grain Slope	Expression of the angle of the grain to the long edges of the veneer component.

Grain Sweep	Expression of the angle of the grain to the long edges of the veneer component over the area extending 1/8 of the length of the piece from ends.
Gum Pockets	Well-defined opening between rings of annual growth, containing gum or evidence of prior gum accumulations.
Gum Spots & Streaks	Gum or resinous material of color spots caused by prior resin accumulations sometimes found on panel surfaces.

— H —

Hairline	Thin, perceptible line showing at the joint of two pieces of wood.
Heartwood	The nonactive center of a tree generally distinguishable from the outer portion (sapwood) by its darker color.
Holes, Worm	Holes resulting from infestation by worms greater than 1/16 inch (1.6 mm) in diameter and not exceeding 5/8 inch (16 mm) in length.

— I —

Inconspicuous	Barely detectable with the naked eye at a distance of 6 ft to 8 ft.
Indentations	Areas in the face that have been compressed as the result of residue on the platens of the hot press or handling damages through the factory.

— J —

Joint	The line of juncture between the edges or ends of two adjacent sheets of veneer.
Joint, Open	Joint in which two adjacent pieces of veneer do not fit tightly together.

— K —

Kiln-Dried	Lumber dried in a closed chamber in which the removal of moisture is controlled by artificial heat and usually by relative humidity.
Knife Marks	Very fine lines that appear across the panel that can look as though they are raised resulting from some defect in the lathe knife that cannot be removed with sanding.
Knot	Cross section of tree branch or limb with grain usually running at right angles to that of the piece of wood in which it occurs.
Knot Holes	Voids produced by dropping of knots from the wood in which they were originally embedded.
Knots, Blending Pin	Sound knots 1/4 inch or less in diameter that do not contain dark centers. Blending pin knots are detectable at a distance of 6 feet to 8 feet and do not seriously detract from the overall appearance of the panel.
Knots, Open	Openings where a portion of the wood substance of the knot was dropped out, or where cross checks have occurred to present an opening.
Knots, Pin	Sound knots $\frac{1}{4}$ inch (6 mm) or less in diameter containing dark centers.
Knots, Sound, Tight	Knots that are solid across their face and fixed by growth to retain their place.

— L —

Lap	A condition where the pieces of veneer are so misplaced that one piece overlaps the other and does not make a smooth joint.
Lock Block	A concealed block the same thickness as the door stile or core which is adjacent to the stile at a location corresponding to the lock location and into which a lock is fitted.

— M —

Matching Edge Band (ME)	Edge band must be the same species as the face veneer.
Medium Density	The generic name for a panel manufactured from lignocellulosic fibers combined with a synthetic resin or other

Fiberboard (MDF)	suitable binder and bonded together under heat and pressure in a hot press by a process in which the entire bond is created by the added binder.
Medium Density Overlay	A thermosetting resin impregnated paper applied to a door face to provide the optimum surface for paint finish.
Mineral Stain	Olive and greenish-black streaks believed to designate areas of abnormal concentration of mineral matter; common in hard maple, hickory, and basswood: also called "Mineral Streak".
Mineral Streaks	See "Mineral Stain".
— N —	
Not restricted	Allowed, unlimited.
— O —	
Occasional	A small number of characteristics that are arranged somewhat diversely within the face.
— P —	
Patches	Matching wood pieces carefully inserted and glued into the door face after defective portions have been removed.
Plain Sliced	Flat cut. 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.
Pleasing Match	A face containing components which provides a pleasing overall appearance. The grain of the various components need not be matched at the joints. Sharp color contrasts at the joints of the components are not permitted.
Prefitting	Trimming of the door for width and/or height.
Puttied	See "fill".
— Q —	
Quarter Cut	A series of stripes is produced. These stripes vary in width from species to species. A natural distribution of ray fleck (flake) is a characteristic of this cut in red and white oak.
— R —	
Ray	Ribbon-shaped strand of tissue extending in a radial direction across the grain, so oriented that the face of the ribbon is exposed as a fleck on the quarter surface. Also know as "Wood Ray".
Ray Fleck	See "Fleck, Ray".
Repairs	A patch, shim, or filler material inserted and/or glued into veneer or a panel to achieve a sound surface.
Repairs, Blending	Wood or filler insertions similar in color to adjacent wood so as to blend well.
Rift	A parallel grain pattern resulting from sawing a quartered log at right angles to the radius of the log.
Rift Cut	The cut slices slightly across the medullary rays, accentuating the vertical grain and minimizing the ray fleck (flake). Rift grain is restricted to red and white oak.
Rotary Cut	This cut follows the log's annual growth rings, providing a generally bold random appearance.
Rough Cut	Irregular shaped areas of generally uneven corrugation on the surface of veneer.
— S —	
Sanding (Chatter, Dust, Burns)	The degree of defects allowed in sanding of the face.
Sapwood	The living wood of lighter color occurring in the outer portion of a tree.
Shake	A separation along the grain of wood in which the greater part occurs between the rings of annual growth.

Sharp Contrast	For the purpose of this standard, this term means the veneer of lighter than average color should not be joined at the edges with veneer of darker than average color, and that two adjacent pieces of veneer should not be widely dissimilar in grain, figure and natural character markings.
Shims	A split repaired in a piece of wood veneer, preferably from the same piece of veneer from which the face is made to ensure good color and grain match. The grain running in the same direction as the split to be inconspicuous to the naked eye, and free of any gaps where the shim joins the veneer. To be glued into the split and sanded after being made. Color matched.
Show Through (Telegraphing)	A defect caused by the outline and/or surface irregularities, such as frame parts, core laps, voids, etc. that is visible through the face veneers.
Skin	The hardwood plywood (usually 3-ply), hardboard or composition panel, whether flat or configured, which are used for facings for flush wood doors.
Slight	Visible on observation, but does not interfere with the overall aesthetic appearance.
Splits, Hairline	A perceptible separation or absence of wood fiber running parallel with the grain.
Standard Door	By industry practice, a standard door is book size in both width and height.
Stiles/Vertical Edges	The upright or vertical pieces of the core assembly of a wood flush door. Measurement The width of the vertical edge/stile shall be measured at its widest side (the wide side of a beveled door).
— T —	
Tape	Strips of gummed paper used to hold the edges of the veneer together at the joints prior to gluing.
Telegraphing	See "Show Through"
— V —	
Vine Streaks (Mark.)	Scars in the wood generally caused by the stems of clinging vines or by their hair-like roots which cling to the tree trunk. Live vine streaks produce sound scars. Dead vine streaks contain either dead residue of the vine, or the remaining pocket similar to bark pocket. Most vine streaks run across the grain, and therefore, all vine streaks are considered defects in accordance with restrictions described in these rules.
Voids	See "Gaps".
— W —	
Warp	Any distortion in the plane of a door itself and not its relationship to the frame of jamb in which it is to be hung. The term warps includes bow, cup and twist, which are defined as follows: Bow A flat wise deviation from a straight line drawn from top to bottom; a curvature along the length of the door. Cup A deviation from a straight line drawn from side to side; a curvature along the width of the door. Twist A deviation in which one or two corners of the door are out of plane with the other corners of the door.
Wood Flush Door	As assembly consisting of a core and one or more edge bands, with 2 plies of wood veneer with laminate, wood, or wood derivative on each side. All parts are composed of wood, wood derivatives or high pressure decorative laminates.
Worm Track or Scar	The groove or resulting scar tissue in the wood caused by worms or other borers.