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**SECTION 06 4223**  
**5-PIECE DOORS AND MOLDINGS**

This Section specifies Wilsonart® 5-Piece Door Program featuring Thermally Fused Laminate (TFL) surfacing produced by Wilsonart. When combined with Wilsonart's full array of edgebanding options and companion molding trim units, Wilsonart offers a complete suite of products unmatched in the industry for coordinated color, pattern, and finish selections, and will satisfy virtually any residential or commercial need.

Wilsonart® 5-Piece Door Program offerings are well suited for Retail, Hospitality, Residential, Healthcare, Education, and Contract Furniture applications. TFL surfaces provide excellent wear and high resistance to stains and scratches. Additionally, urea-formaldehyde-free fabrications are available.

Section Editing: Informational notes will appear as "Editing Note" text boxes throughout this Section. Bracketed bold text will require a selection to be made or information to be inserted.

**PART 1 - GENERAL**

**1.01 SECTION INCLUDES**

**EDITING NOTE:** Revise listing to suit Project requirements.

- A. 5-piece doors.
- B. Edgebanding.
- C. Accessory moldings.

**1.02 RELATED REQUIREMENTS**

**EDITING NOTE:** Section listings below are common references and based on the broadly accepted CSI MasterFormat® for Section numbers and titles. Revise to suit requirements for particular project.

- A. Section 01 3300 - Submittal Procedures.
- B. Section 06 4116 - Plastic-Laminate-Clad Architectural Cabinets.
- C. Section 06 4219 - Thermally-Fused Laminate Panels.
- D. Section 08 1423.16 - Plastic-Laminate-Faced Wood Doors.
- E. Section 12 3530.13 - Kitchen Casework.
- F. Section 12 3530.23 - Bathroom Casework.
- G. Section 12 3623.13 - Plastic-Laminate-Clad Countertops.

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### 1.03 REFERENCES

**EDITING NOTE:** Revise Reference Standards to suit Project requirements.

- A. Reference Standards:
1. ANSI: American National Standards Institute.
  2. ANSI A208.2: Medium Density Fiberboard (MDF) For Interior Applications.
  3. ANSI/NEMA LD-3: High Pressure Decorative Laminates.
  4. AWI: Architectural Woodwork Institute.
  5. AWMAC: Architectural Woodwork Manufacturers Association of Canada.
  6. AWS: Architectural Woodwork Standards.
  7. KCMA: Kitchen Cabinet Manufacturers Association.
  8. KCMA A161.1: Performance & Construction Standard for Kitchen and Vanity Cabinets.
  9. NEMA: National Electrical Manufacturers Association.
  10. WI: Woodwork Institute.

### 1.04 DEFINITIONS

**EDITING NOTE:** Revise Definitions to suit Project requirements.

- A. 5-Piece Doors: Stile-and-rail TFL-clad composite wood core doors with solid inset facer panels.
- B. TFL: Thermally fused laminate.

### 1.05 SUBMITTALS

- A. General: Submit under provisions of Section 01 3300 - Submittal Procedures.
- B. Product Data: Submit the following:
1. Product data for each specified product. Include manufacturer's technical data sheets and published instruction instructions.
- C. Shop Drawings: Fully dimensioned shop drawings showing layouts and components, including edge conditions, joinery, terminating conditions, and substrate construction. Include elevations, section details, and large scale details. Indicate color, pattern, and finish selections.
- D. Samples: Selection and verification samples for each color, pattern, and finish required.
- E. Quality Assurance Submittals:
1. Test Reports: Certified test reports showing compliance with specified performance characteristics and physical properties, if required.
  2. Qualifications: For Installer.

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**1.06 QUALITY ASSURANCE**

- A. Installer Qualifications: Minimum of three years documented installation experience for projects similar in scope and complexity to this Project.
- B. Mock-Up:

<b>EDITING NOTE:</b> Select mock-up size option. Delete entire paragraph if mock-up is not a Project requirement.
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- 1. Install at Project site using acceptable products and manufacturer approved installation methods. Obtain Architect's acceptance for color, pattern, finish, fabrication, and installation standards.
- 2. Mock-Up Size: [ \_\_\_\_\_ ] by [ \_\_\_\_\_ ].
- 3. Mock-Up Size: Indicated on Drawings.
- 4. Mock-Up Location: **[Indicated on Drawings] [As directed by Architect].**
- 5. Maintain mock-up during construction for fabrication and installation comparison. If required, remove and legally dispose of mock-up when no longer required.
- 6. Incorporation: If permitted by Architect, mock-up may be incorporated into as part of the completed Work.

**1.07 DELIVERY, STORAGE, AND HANDLING**

- A. Delivery: Do not deliver 5-piece doors and accessory moldings until painting and similar wet operations have been completed in scheduled installation areas. Deliver in manufacturer's standard protective packaging with identifying labels intact.
- B. Storage and Protection: Store 5-piece doors and accessory moldings protected from exposure to harmful weather conditions and other potential sources of damage. If stored in other than installation areas, comply with environmental requirements under "Project Conditions" Article.

**1.08 PROJECT CONDITIONS**

- A. Environmental Requirements: Install 5-piece door assemblies only when the building HVAC system is operating and maintaining a temperature of approximately 75 deg F and 45 percent to 55 percent relative humidity for the duration of the construction period.
- B. Field Measurements: Verify actual measurements by field measurements before fabrication; show recorded measurements on shop drawings. Coordinate field measurements and fabrication schedule with construction progress to avoid construction delays.

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**PART 2 - PRODUCTS**

**WILSONART CONTACT INFORMATION:** Wilsonart LLC, 2501 Wilsonart Drive, Temple, TX 76504. Tel. 254.207.7000, Toll-Free 800.433.3222, Fax 254.207.3209.  
Website: [www.wilsonart.com](http://www.wilsonart.com)

**2.01 MANUFACTURER**

- A. Basis of Design: Wilsonart LLC.

**EDITING NOTE:** Refer to the **Coordinated Surfaces Page** under the **Products** tab on the Wilsonart website for complete information on laminate properties, including compliance with additional standards and physical performance properties.

**2.02 LAMINATE PROPERTIES**

- A. Laminate Composition: Melamine saturated decorative layers thermally fused to both door core face surfaces with heat and pressure. Stain resistant surface with excellent wear and scratch resistance.
- B. Core Material: Composite product composed primarily of cellulosic materials and a bonding system, resulting in a durable and dimensionally stable substrate suitable for decorative laminate overlays.

**2.03 5-PIECE DOORS**

- A. Product: "Wilsonart® 5-Piece Door Program." **[Comply with KCMA A161.1 and provide KCMA certification label on door].**
- B. Laminate Properties:
1. Laminate Conformance Standard: ANSI/NEMA LD 3, Grade VGL.
  2. Laminate Thickness: 0.020 inch, nominal.
  3. Color, Pattern, and Finish: **[Cafelle, Textured Gloss Finish] [Shaker Cherry, Textured Gloss Finish] [River Cherry, Fine Velvet Texture Finish] [Colombian Walnut, Textured Gloss Finish] [NeoWalnut, Fine Velvet Texture Finish] [Florence Walnut, Fine Velvet Texture Finish] [Ebony Recon, Fine Velvet Texture Finish] [White Driftwood, Casual Rustic Finish] [Weathered Char, Casual Rustic Finish] [Saddle Oak, Casual Rustic Finish] [Branded Oak, Casual Rustic Finish] [Fawn Cypress, Casual Rustic Finish] [Veranda Teak, Gloss Line Finish] [Phantom Pearl, Gloss Line Finish] [Phantom Ecru, Gloss Line Finish] [Phantom Charcoal, Gloss Line Finish] [Linen, Matte Finish] [\_\_\_\_\_].**

**EDITING NOTE:** If color, pattern, and finish are not specified in the subparagraph above, delete and select one of the following subparagraphs.

4. Color, Pattern, and Finish: Specified in SCHEDULE Article of this Section.
5. Color, Pattern, and Finish: Indicated on Drawings.

- 6. Color, Pattern, and Finish: Selected from manufacturer's full range of available designs.

**EDITING NOTE:** 5-Piece Doors utilize a medium density fiberboard core material. Default Grades specified are typical performance values. Other grades can be specified; refer to the **Substrate Selection Technical Bulletin** under the Resources tab on the Wilsonart website for additional information.

- C. Core Material: Medium density fiberboard **[with no added urea formaldehyde]**.
  - 1. Conformance Standard: ANSI 208.2. Grade **[130]**.
  - 2. Thickness, Stiles and Rails: 3/4 inch with  $\pm 0.008$  inch dimensional tolerance.
  - 3. Thickness, Inset Facer Panels: 1/4 inch with  $\pm 0.008$  inch dimensional tolerance.
- D. Door Dimensions: **[As indicated or scheduled on Drawings]** [\_\_\_\_\_].

**EDITING NOTE:** Several designs are available for 5-Piece Doors, including doors serving as drawer fronts. Select from the following design options to suit project requirements.

- E. Shaker Door Rail/Stile Design: **[2.25" Narrow Shaker Door] [2.25" Narrow Shaker Door, Mitered] [3" Wide Shaker Door] [3" Wide Shaker Door, Mitered]**.
- F. Shaker Drawer Front Rail/Stile Design: **[2.25" Narrow Shaker Drawer] [2.25" Narrow Shaker Drawer, Mitered] [3" Wide Shaker Drawer] [3" Wide Shaker Drawer, Mitered]**.
- G. Contemporary Door Rail/Stile Design: **[Contemporary Shaker Door, Mitered] [Contemporary Shaker Door, French Cut]**.
- H. Contemporary Drawer Rail/Stile Design: **[Contemporary Shaker Drawer, Mitered] [Contemporary Shaker Drawer, French Cut]**.
- I. Combination Door Rail/Stile Design: Combination Door.
- J. Combination Drawer Rail/Stile Design: Combination Drawer.

**EDITING NOTE:** If the door design(s) are not specified in the paragraphs above, delete and select one of the following paragraphs.

- K. Door Design(s): Specified in SCHEDULE Article of this Section.
- L. Door Design(s): Indicated on Drawings.
- M. Door Design(s): Selected from manufacturer's full design range.

## 2.04 DECORATIVE EDGE BANDS

- A. Edgeband Products: "Wilsonart® Edgeband."
  - 1. Composition: ABS/PVC extruded fabrication.
  - 2. Width: Equal to door thickness.
  - 3. Color, Pattern, and Finish: **[Match doors]** [\_\_\_\_\_].

## 2.05 ACCESSORY MOLDINGS

- A. Product Manufacturer: Wilsonart LLC.
1. Composition: Medium density fiberboard.
  2. Profile(s): **[Light Shield] [Batten] [Contemporary Crown] [Concave Crown] [Baseboard]**.
  3. Applications: As indicated on Drawings **[including molding profile combinations]**.
  4. Color and Pattern: **[Match doors] [\_\_\_\_\_]**.

<b>EDITING NOTE:</b> If color and pattern selections are not specified above, delete and select from one of the following options.
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5. Color and Pattern: Specified in SCHEDULE Article of this Section.
6. Color and Pattern: Indicated on Drawings.
7. Color and Pattern: Selected from manufacturer's full range of available selections.

## 2.06 FABRICATION

- A. Fabricate 5-piece doors and accessory moldings in shop, to greatest extent practicable, in sizes and shapes indicated according to approved shop drawings and manufacturer's published fabrication requirements.

## PART 3 - EXECUTION

### 3.01 EXAMINATION

- A. Examine substrates and conditions that could adversely affect the work of this Section.
- B. Substrates must be sound, flat, smooth, and free from dust or other surface contaminants.
- C. Commencement of work will constitute acceptance of existing conditions and substrates to receive the work.

### 3.02 INSTALLATION

- A. Conformance Standard: Comply with **[AWI/AWMAC/WI AWS] [and] [KCMA A161.1]** as applicable to Project.
- B. Install 5-piece doors and accessory moldings plumb, level, and true according to approved shop drawings and manufacturer's published installation instructions.

1. Coordinate installation with related work specified under Article 1.02 Related Requirements.
- C. Attach 5-piece doors and accessory moldings to substrates as indicated on Drawings.

### **3.03 CLEANING AND PROTECTION**

- A. Completely remove deleterious substances from finished surfaces using a mild solution of 5 percent soap to 95 percent water applied with a damp (not wet) cloth. Dry surfaces with a soft clean cloth.

### **3.04 SCHEDULE**

**OPTION:** A schedule for 5-piece door designs and color, pattern, and finish selections may be inserted here if this option is chosen.

**END OF SECTION 06 4223**