



# Keystone's Grain Matching Process

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Keystone Wood Specialties can grain match PRO-COR and PRO-COR-SE doors from a particular sheet of material, upon request.

## Keystone Custom Matching Process

Please follow our Grain Matching Process and complete our Grain Matching Order Form to ensure the best results for your project.

### Step 1: Identify the items you would like to grain match

Identify, with the homeowner, what items on the order you would like to have grain-matched. Note: our grain matching is limited to what can be nested into a 4' x 8' sheet of material if the grain runs vertically, or an 8' x 4' sheet if the grain runs horizontally. The grain matching will be within that particular sheet. The grain will not match from one sheet to another sheet.

### Step 2: Print out the order form

#### Draw on the templates

There are two templates available: one for vertical grain, and one for horizontal grain. Print out the appropriate form and draw on the sheet templates the items you would like to be cut from that particular sheet. There are guides on each sheet every 6" to assist you. Unless specified otherwise, we will assume 1/8" is removed between each piece. After you draw each item, label each item with a letter (which identifies the sheet) and a number (which identifies a particular item on the sheet). Example, the first sheet is sheet A. The first piece on sheet A would be identified as "A-1." The second item on sheet A would be "A-2." The first piece on the next sheet would be "B-1," etc. When you list the sizes and details of the order you will need to reference this code.

#### List the sizes

Beside the drawing templates are a list of specific details needed for each item. Fill this out using the sheet letter and item number you assigned to each part. Include the width and height of each item, any necessary hinging information, as well as indication of where you would like the item to be ID stamped. Typically Wall Cabinet doors are stamped on the top and Base Cabinet doors and drawer fronts are stamped on the bottom.



### **Step 3: Send the forms to Keystone**

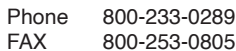
Send your forms to Keystone, and we will verify material availability, confirm the sizes listed will fit on the sheets and provide an acknowledgement with pricing and lead times, as well as your original order form.

### **Step 4: Approve & return to Customer Service**

After receiving our acknowledgement, along with a copy of your original order form, either approve or make any necessary changes. If the layout is the same, but sizes change, you only need to make sizing changes to the acknowledgement. If the layout changes, you will need to fill out and submit a new order form, which includes the drawings on the sheets and the list of sizes.

### **Frequently asked questions:**

1. **Can I make the grain match from sheet to sheet?** *We currently do not offer Sequence-matched doors, where the grain pattern continues from one sheet of material to the next. We only match grain within one sheet.*
2. **How uniform will the grain be between sheets.** *Because we do not produce plywood, we order enough sheets to produce each order. This does not allow us to select for color and grain uniformity the way we can with solid lumber. Therefore, the color and grain patterns will vary from sheet to sheet based on the variance of the particular wood species and based on the highest grading for sheet material. All faces are A grade veneer. Stained finishes tend to reduce the contrast in color, whereas natural finishes tend to highlight the differences in color and grain patterns.*
3. **What happens if I mismeasured an item and I need to reorder?** *If you need a replacement item that was grain-matched, the only way for that item to continue to be grain-matched is to reorder each of the items that were cut from that sheet. If you reorder only one item from a sheet, it is no longer considered to be "grain-matched" with the other items.*
4. **Is grain-matching available on any other door designs?** *Grain matching is currently only available on ProCor and ProCorSE doors.*



P.O.# \_\_\_\_\_ JOB # \_\_\_\_\_

# GRAIN MATCH ORDER FORM

DOOR DESIGN: ProCor or ProCorSE

WOOD SPECIES: \_\_\_\_\_ FINISH: \_\_\_\_\_

[illegible]

Phone 800-233-0289  
FAX 800-253-0805

- ☐ ORDER PENDING
- ☐ ORDER RELEASED FOR PRODUCTION
- ☐ QUOTATION

PAGE 1 of 1

ORDERED BY John ORDER DATE 2/4/18

CO. NAME ABC Woodworking

ADDRESS 52 First St.

ADDRESS \_\_\_\_\_

CITY Philadelphia STATE PA ZIP 19092

PHONE # 555-123-4567 FAX # \_\_\_\_\_

E-mail \_\_\_\_\_

P.O.# \_\_\_\_\_ JOB # \_\_\_\_\_

# GRAIN MATCH ORDER FORM

DOOR DESIGN: ProCor or ProCorSE

WOOD SPECIES: White Oak, plain sawn FINISH: Natural

Figure 1: Schematic diagram of a four-quadrant experimental design. The figure is divided into four quadrants labeled A, B, C, and D. Each quadrant contains a grid of cells. Quadrant A (top-left) has five cells labeled A-1, A-2, A-3, A-4, and A-5. Quadrant B (top-right) has four cells labeled B-1, B-2, B-3, and B-4. Quadrant C (bottom-left) has two cells labeled C-1 and C-2. Quadrant D (bottom-right) is empty. A vertical double-headed arrow labeled 'GRAIN DIRECTION' is positioned between the top and bottom quadrants.

[illegible]