

## SPECIFICATIONS OVERVIEW

### General Scope

- Cabinets are designed and constructed in the style of overlay cabinetry, sometimes referred to as “European Style” cabinetry. When closed, all doors and drawers rest with the back side of their panels flat against any adjacent framing or railing so that minimal framing or railing is visible from a front facing position.
- Our cabinets are designed as modular units that can be moved into any position in line as finished side panels may be fastened at any time to any cabinet side wall. Access and/or passage holes are included for electrical, plumbing, and ventilation as required.
- All components of cabinet assemblies are constructed from stainless steel materials - including drawer bodies, cabinet walls, cabinet ceilings, cabinet floors, shelves, drawer and door panel assemblies, as well as all hardware (including drawer slides and door hinges. The only exception to this shall be the plastic and/or rubber components necessary for bumpers, cylinders, and padding for soft-closing, self-closing, and hold-close mechanisms.

### Design Features

#### Sound Deadening Core

- Drawer and door panel assemblies are bonded together via a sound-deadening foam stiffener substrate and welded together in each coincident corner thereafter.

#### Hinges

- Soft-closing hinges
- Hinges offer three dimensions of adjustability.

#### Drawer Slides

- Drawers feature heavy duty, full extension slides rated for 77 pounds per set.
- Drawers over 12 inches tall and/or 24 inches wide will feature (2) sets of drawer slides to accommodate a greater load rating. Extra sets of drawer slides shall be made available for all drawer sizes upon request.
- Soft-closing drawer slides with hold close mechanisms.
- Lever disconnection for easy drawer removal and installation.

#### Stainless Steel Leveling Feet (Base Cabinets)

- Leveling feet have 1 ½ inches of adjustability.
- Load capacity of up to 2,000 pounds (exceeds cabinet load capacity).
- Leveling feet are welded to floor channels with no holes or visibility from inside the cabinet.

### Base Cabinet Materials

#### Floor Channels

- 300 Series Stainless Steel, 14G (.0751”).

#### Door and drawer panels, shelves, walls, floors, ceiling headers and corner brackets, drawer bodies, drawer and door frames, and any other finished panels not mentioned prior.

- 300 Series Stainless Steel, 18G (.0480”).

#### Hinges

- 300 Series Stainless Steel.
- Attached to door and cabinet walls using 300 series stainless steel #8 fasteners.

## SPECIFICATIONS OVERVIEW

### Drawer Slides

- 200 Series Stainless Steel, .039" (1mm).
- Stainless steel ball bearings and springs.
- Small non-structural components of plastic and/or rubber for self-closing effects, lever disconnect, and hold-close mechanisms.

## Upper Cabinet Materials

### Floor Channels

- 300 Series Stainless Steel, 22G (.293").

### Door and drawer panels, shelves, walls, floors, ceiling headers and corner brackets, drawer bodies, drawer and door frames, and any other finished panels not mentioned prior.

- 300 Series Stainless Steel, 22G (.0293").

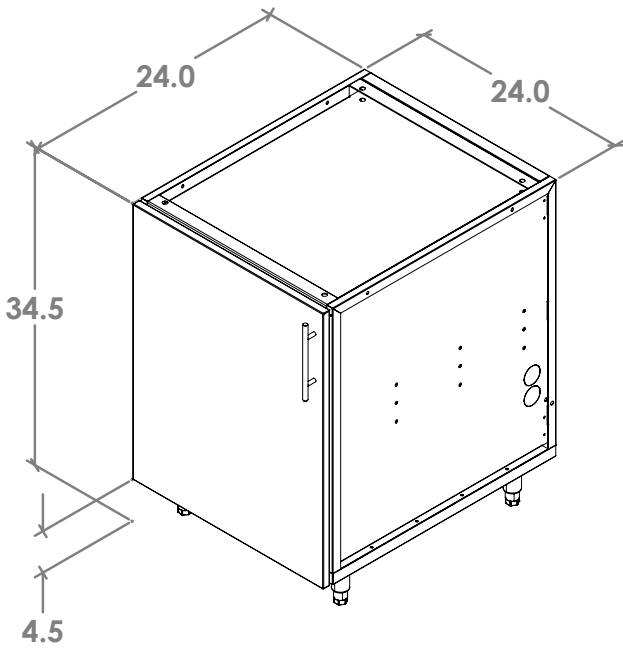
### Hinges

- 300 Series Stainless Steel.
- Attached to door and cabinet walls using 300 series stainless steel #8 fasteners.
- Small non-structural components of plastic and/or rubber for self-closing effects.

## Casework Durability

- Base cabinets support >130 lbs. (90kg) per square foot of top surface area at all walls and ceilings.
- Upper cabinets support >22 lbs. (10kg) per square foot of shelf surface area at all walls and ceilings.
- Leveling feet support up to 2,000 lbs. (900kg) at full 1.5" extension (exceeds cabinet load capacity).
- Shelves support up to 45 lbs. (20kg) per square foot of top surface.
- Drawer slides support up to 77 lbs. (35kg) per pair.

## SINGLE DOOR BASE CABINET

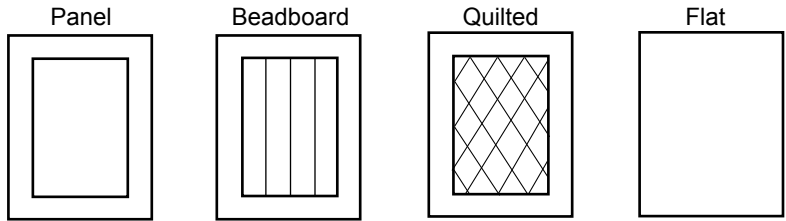


Example Displayed:  
IB-24-24-36-SGLDR-FLAT-R

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"
Depth (Y)	24"   30"   36"
Height (Z)	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

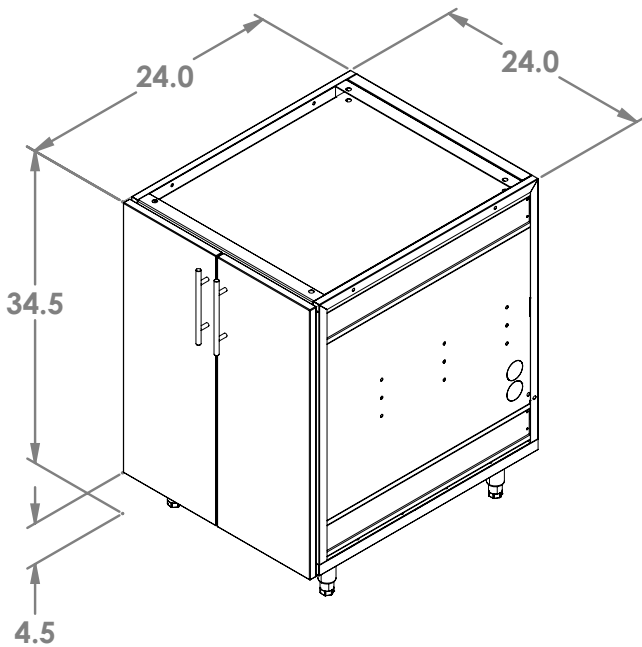
Door Styles:



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IB-(X)-(Y)-(Z)-SGLDR-(Door Style)-(Handle Side)

## DOUBLE DOOR BASE CABINET

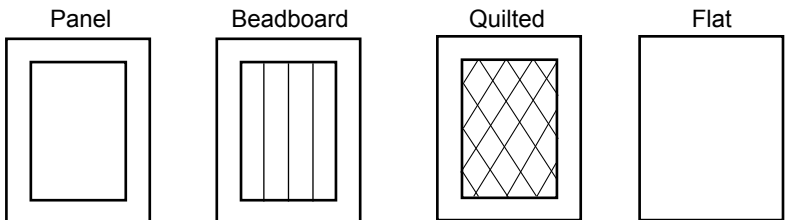


Example Displayed:  
IB-24-24-36-DBLDR-FLAT

Available Dimensions	
Width (X)	24"   27"   30"   33"   36"   39"   42"   45"   48"
Depth (Y)	24"   30"   36"
Height (Z)*	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

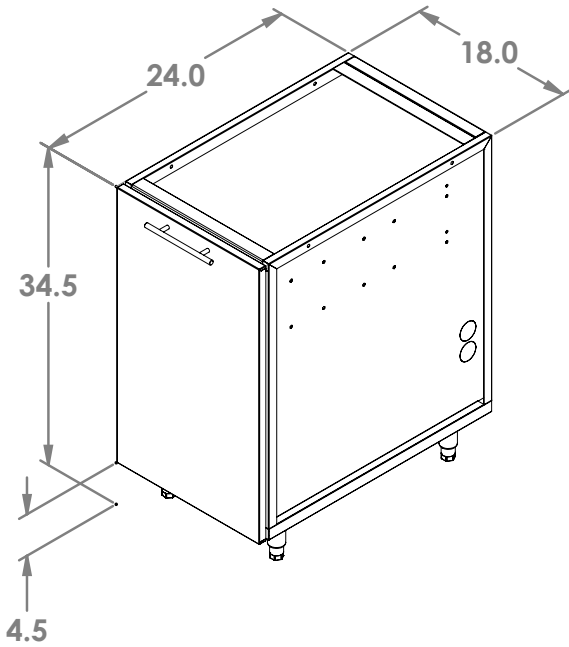
Door Styles:



Insert Width(X), Depth(Y), Height(Z), and Door Style into parts number:

IB-(X)-(Y)-(Z)-DBLDR-(Door Style)

## PULL OUT DOOR BASE CABINET

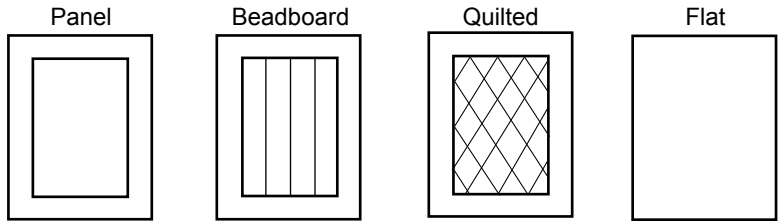


Example Displayed:  
IB-18-24-36-PODR-FLAT

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"
Depth (Y)	24"   30"   36"
Height (Z)	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

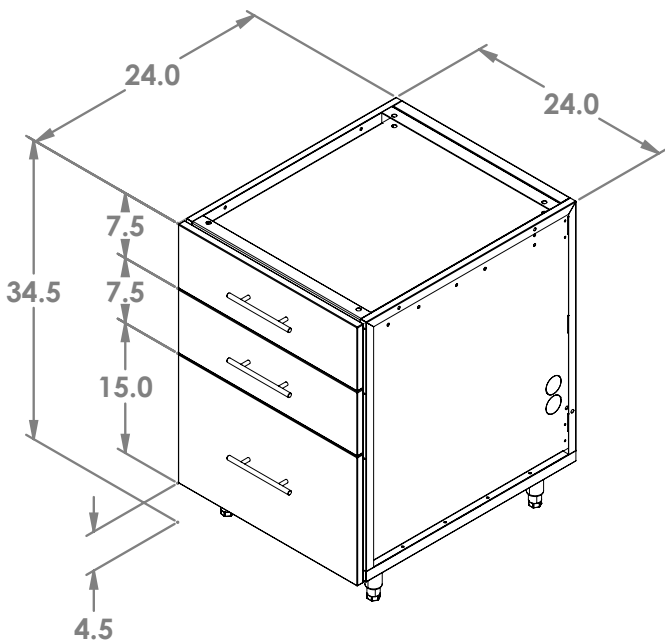
Door Styles:



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IB-(X)-(Y)-(Z)-PODR-(Door Style)

## 2 QUARTER DRAWERS WITH 1 HALF DRAWER BASE CABINET

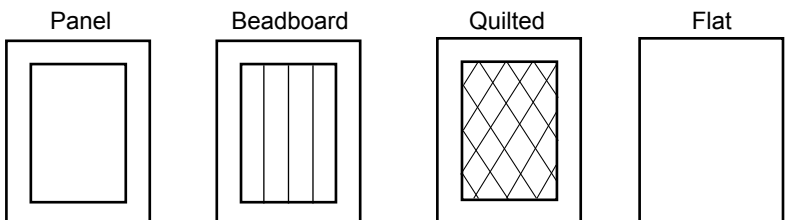


Example Displayed:  
IB-24-24-36-2QDRWHDRW-FLAT

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"   27"   30"
Depth (Y)	24"   30"   36"
Height (Z)*	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

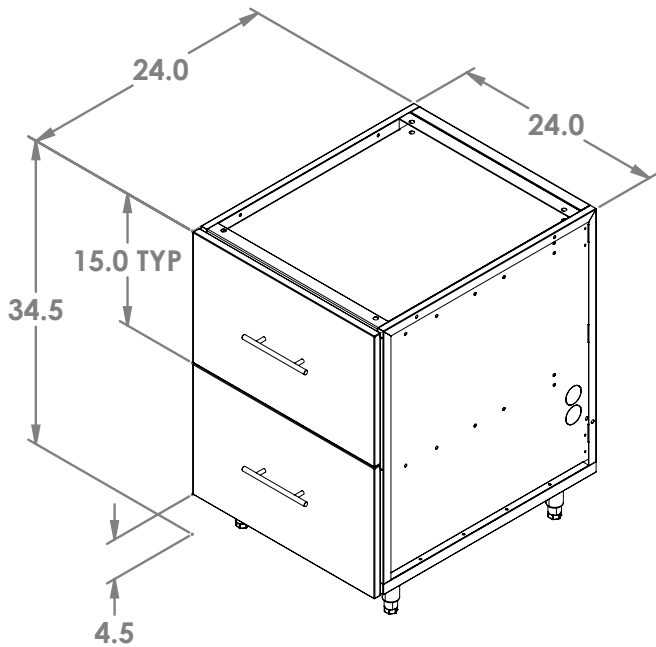
Door Styles:



Insert Width(X), Depth(Y), Height(Z), and Door Style into parts number:

IB-(X)-(Y)-(Z)-2QDRWHDRW-(Door Style)

## 2 HALF DRAWERS BASE CABINET

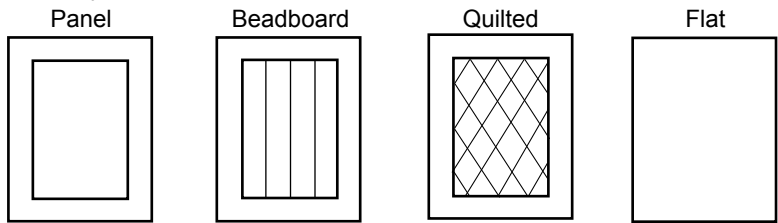


Example Displayed:  
IB-24-24-36-2HDRW-FLAT

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"   27"   30"
Depth (Y)	24"   30"   36"
Height (Z)	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

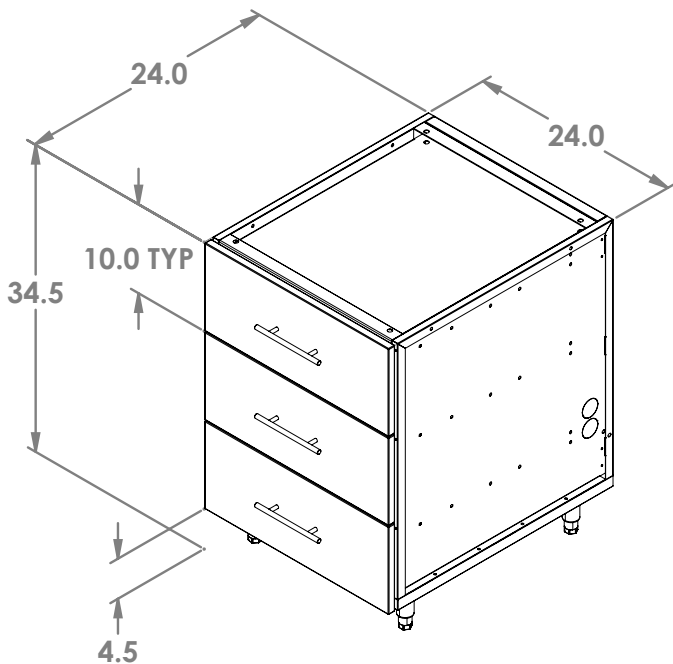
Door Styles:



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IB-(X)-(Y)-(Z)-2HDRW-(Door Style)

## 3 THIRD DRAWERS BASE CABINET

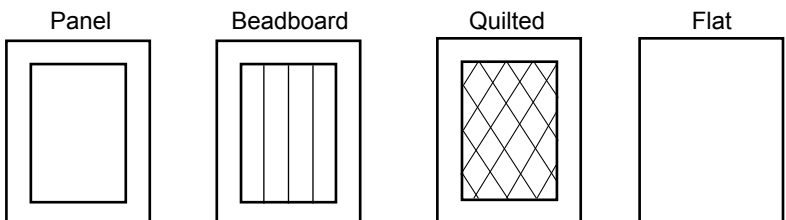


Example Displayed:  
IB-24-24-36-3TDRW-FLAT

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"   27"   30"
Depth (Y)	24"   30"   36"
Height (Z)*	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

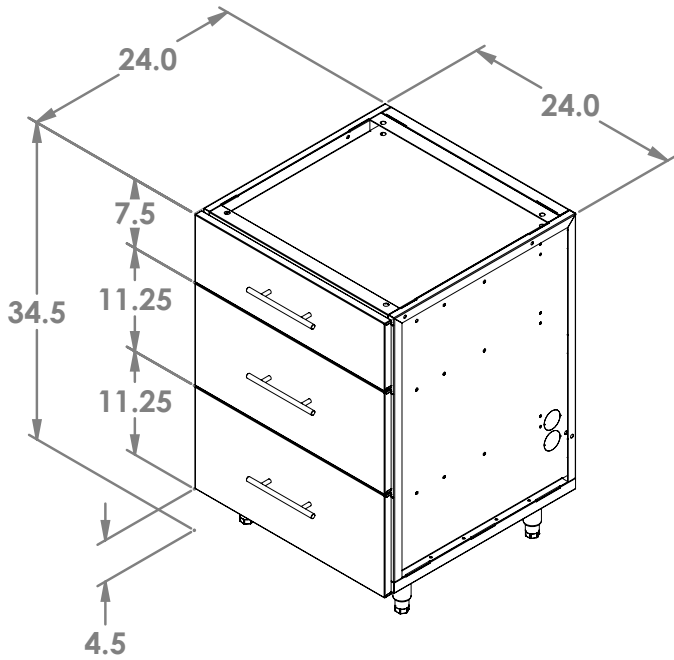
Door Styles:



Insert Width(X), Depth(Y), Height(Z), and Door Style into parts number:

IB-(X)-(Y)-(Z)-3TDRW-(Door Style)

## QUARTER DRAWER THREE EIGHTHS DRAWERS BASE CABINET

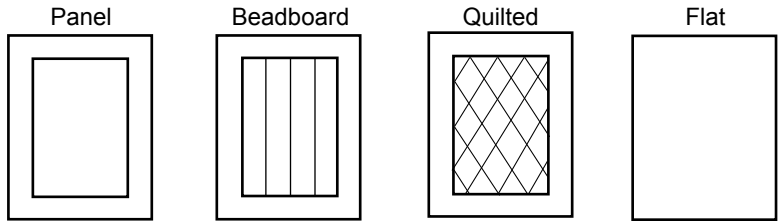


Example Displayed:  
IB-24-24-36-QDRW38DRW-FLAT

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"   27"   30"
Depth (Y)	24"   30"   36"
Height (Z)	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

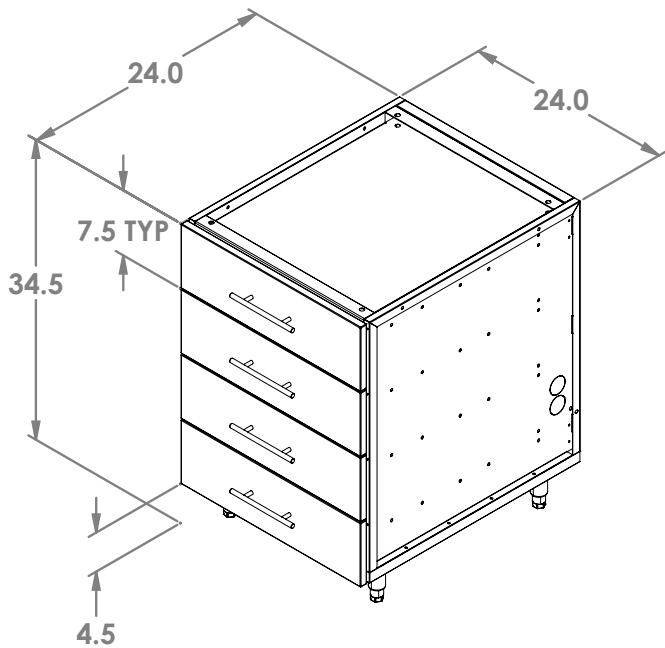
**Door Styles:**



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IB-(X)-(Y)-(Z)-QDRW38DRW-(Door Style)

## 4 QUARTER DRAWERS BASE CABINET

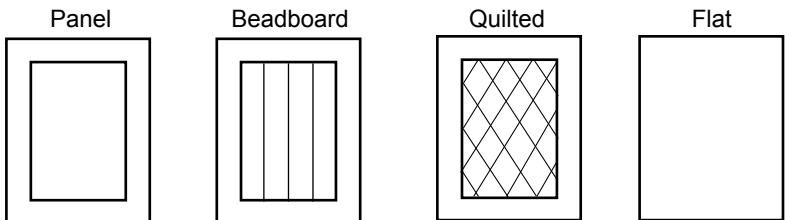


Example Displayed:  
IB-24-24-4QDRW-FLAT

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"   27"   30"
Depth (Y)	24"   30"   36"
Height (Z)*	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

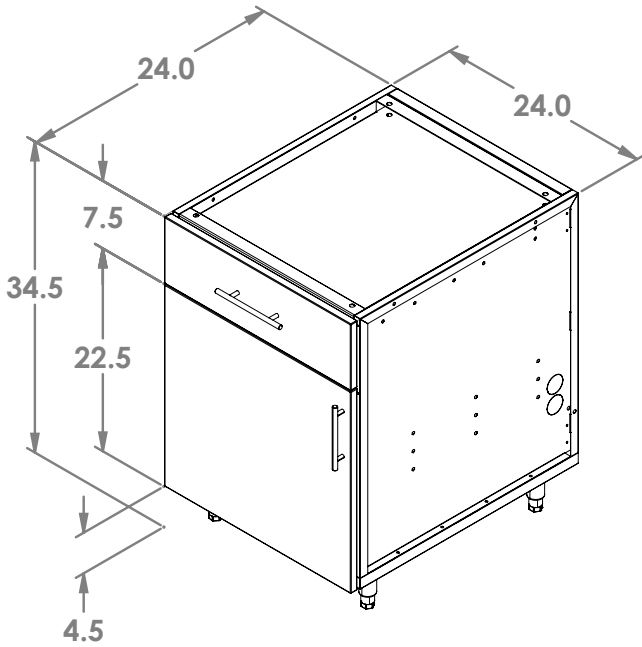
**Door Styles:**



Insert Width(X), Depth(Y), Height(Z), and Door Style into parts number:

IB-(X)-(Y)-(Z)-4QDRW-(Door Style)

## 1 QUARTER DRAWER SINGLE DOOR BASE CABINET

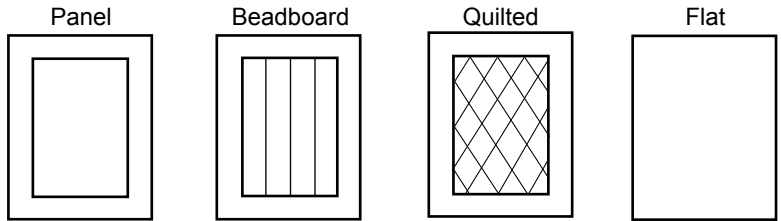


Example Displayed:  
IB-24-24-36-QDRWSDR-FLAT-R

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"
Depth (Y)	24"   30"   36"
Height (Z)	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

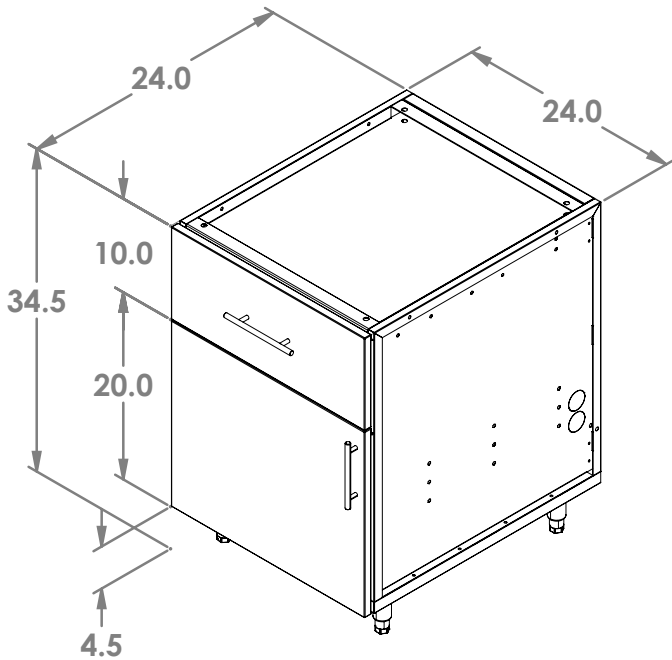
**Door Styles:**



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IB-(X)-(Y)-(Z)-QDRWSDR-(Door Style)-(Handle Side)

## 1 THIRD DRAWER SINGLE DOOR BASE CABINET

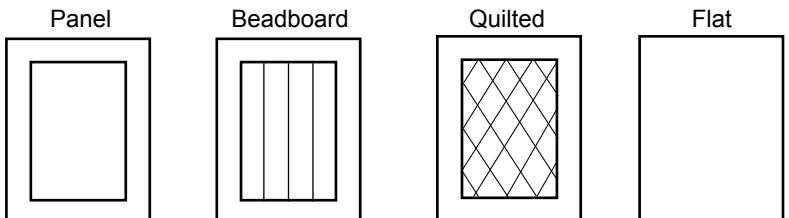


Example Displayed:  
IB-24-24-36-TDRWSDR-FLAT-R

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"
Depth (Y)	24"   30"   36"
Height (Z)*	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

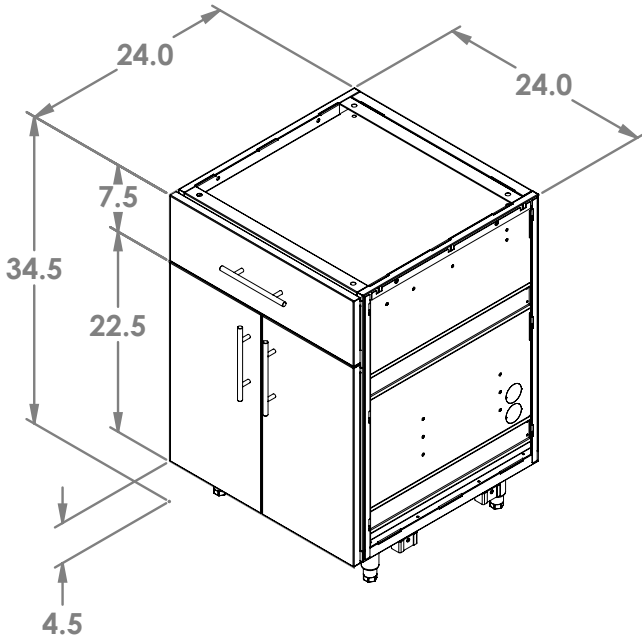
**Door Styles:**



Insert Width(X), Depth(Y), Height(Z), and Door Style into parts number:

IB-(X)-(Y)-(Z)-TDRWSDR-(Door Style)-(Handle Side)

## 1 QUARTER DRAWER DOUBLE DOOR BASE CABINET

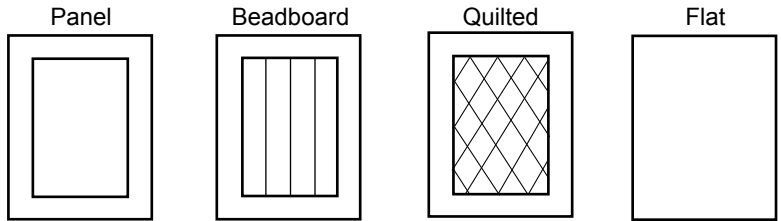


Example Displayed:  
IB-24-24-36-QDRWDBLDR-FLAT-R

Available Dimensions	
Width (X)	24"   27"   30"
Depth (Y)	24"   30"   36"
Height (Z)	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

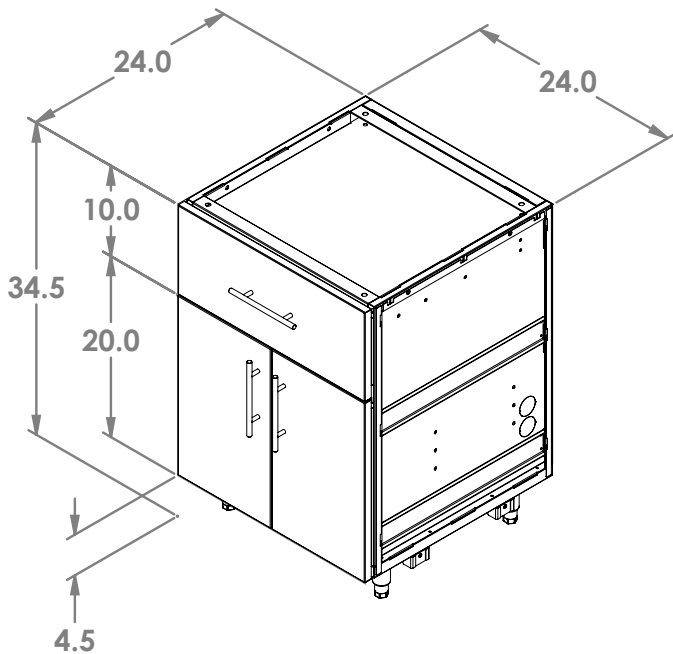
**Door Styles:**



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IB-(X)-(Y)-(Z)-QDRWDBLDR-(Door Style)-(Handle Side)

## 1 THIRD DRAWER DOUBLE DOOR BASE CABINET

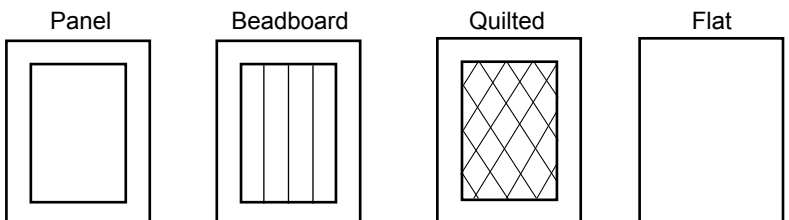


Example Displayed:  
IB-24-24-36-TDRWDBLDR-FLAT-R

Available Dimensions	
Width (X)	24"   27"   30"
Depth (Y)	24"   30"   36"
Height (Z)*	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

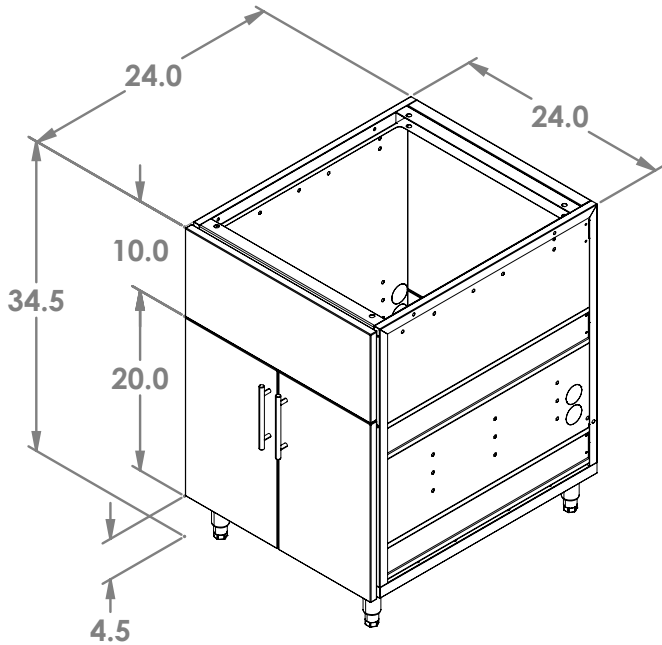
**Door Styles:**



Insert Width(X), Depth(Y), Height(Z), and Door Style into parts number:

IB-(X)-(Y)-(Z)-TDRWDBLDR-(Door Style)-(Handle Side)

## THIRD FALSE DRAWER DOUBLE DOOR SINK BASE CABINET

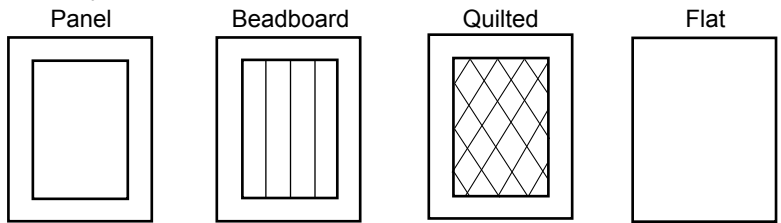


Example Displayed:  
IB-24-24-36-SNKTFDRWDDR-FLAT

Available Dimensions	
Width (X)	24"   27"   30"   33"   36"   39"   42"   45"   48"
Depth (Y)	24"   30"   36"
Height (Z)	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

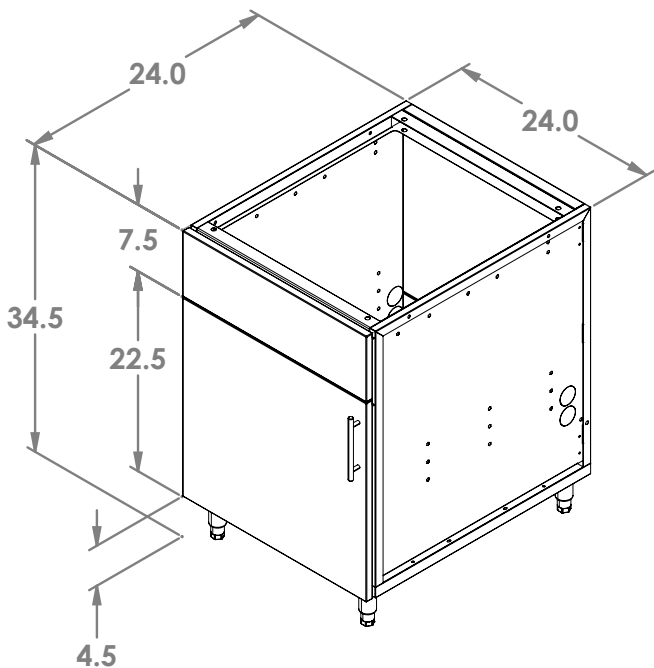
Door Styles:



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IB-(X)-(Y)-(Z)-SNKTFDRWDDR-(Door Style)

## QUARTER FALSE DRAWER WITH SINGLE DOOR SINK BASE CABINET

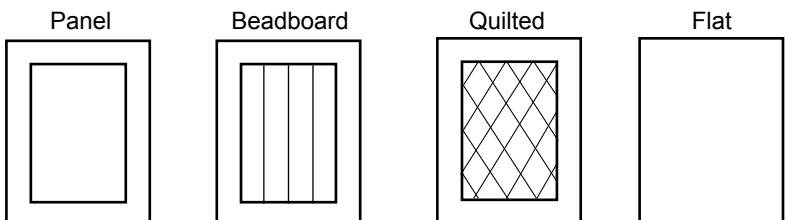


Example Displayed:  
IB-24-24-36-SNKQFDRW-FLAT-R

Available Dimensions	
Width (X)	18"   21"   24"
Depth (Y)	24"   30"   36"
Height (Z)*	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

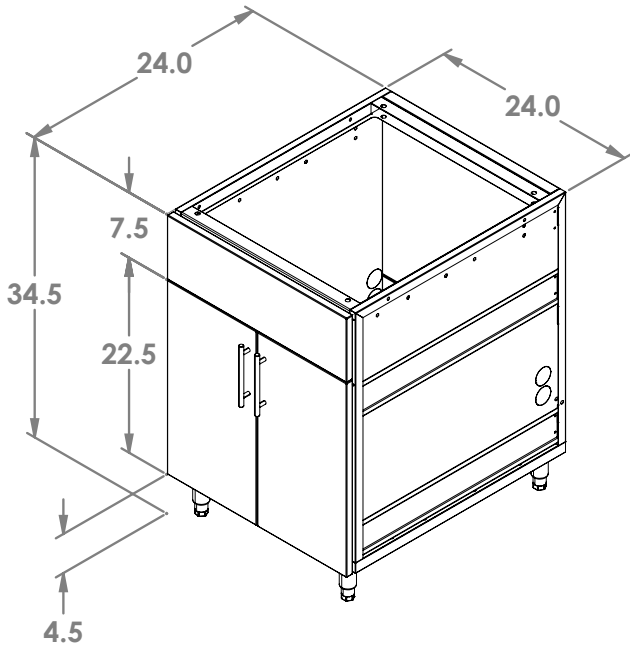
Door Styles:



Insert Width(X), Depth(Y), Height(Z), and Door Style into parts number:

IB-(X)-(Y)-(Z)-SNKQFDRW-(Door Style)-(Handle Side)

## QUARTER FALSE DRAWER WITH DOUBLE DOOR SINK BASE CABINET

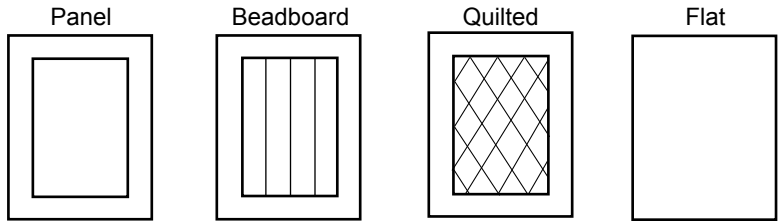


Example Displayed:  
IB-24-24-36-SNKQFDRWDDR-FLAT

Available Dimensions	
Width (X)	24"   27"   30"
Depth (Y)	24"   30"   36"
Height (Z)	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

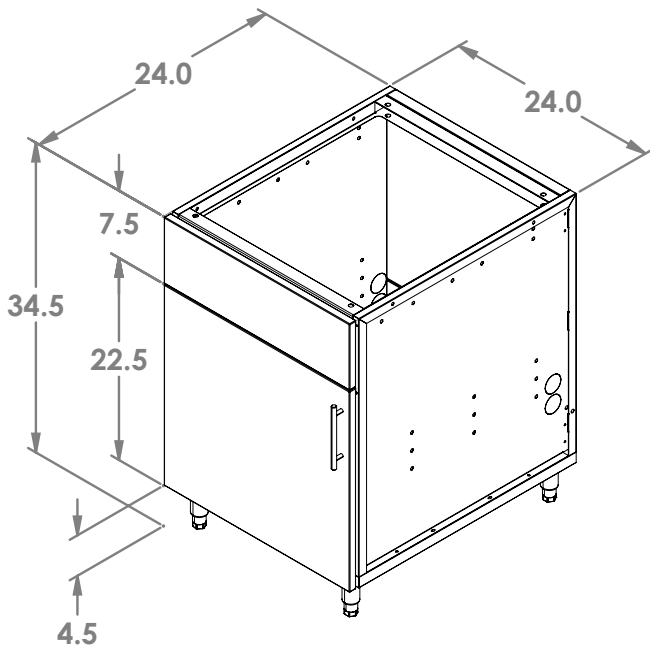
Door Styles:



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IB-(X)-(Y)-(Z)-SNKQFDRWDDR-(Door Style)

## QUARTER FALSE DRAWER SINGLE DOOR SINK BASE CABINET

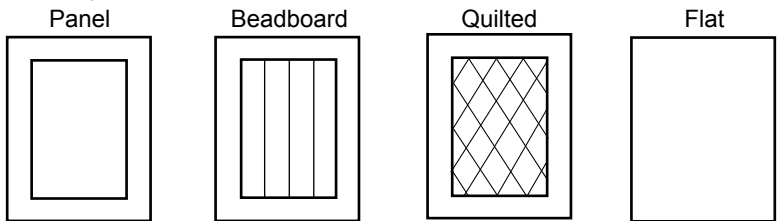


Example Displayed:  
IB-24-24-36-SNKQFDRW-FLAT-R

Available Dimensions	
Width (X)	18"   21"   24"
Depth (Y)	24"   30"   36"
Height (Z)	30"   36"   42"

\* Product heights include standard 1 1/2" countertop (Not Included).

Door Styles:



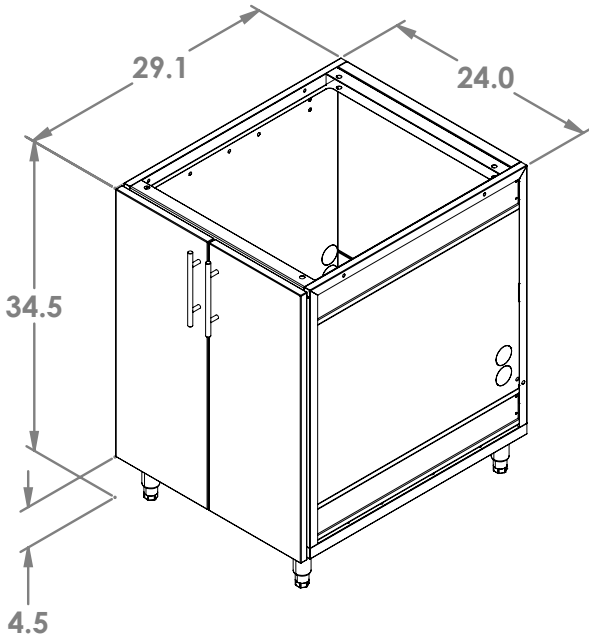
Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IB-(X)-(Y)-(Z)-SNKQFDRW-(Door Style)-(Handle Side)

# Outdoor Base Cabinets



## DOUBLE DOOR SINK BASE CABINET

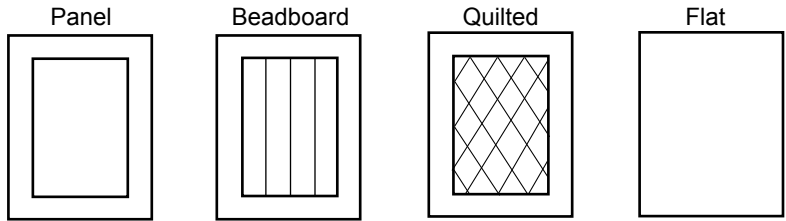


Example Displayed:  
IB-24-30-36-SNKDDR-FLAT

Available Dimensions	
Width (X)	24"   27"   30"   33"   36"   39"   42"   45"   48"
Depth (Y)	24"   30"   36"
Height (Z)	30"   36"   42"

\* Product heights include standard 1 1/2" countertop.

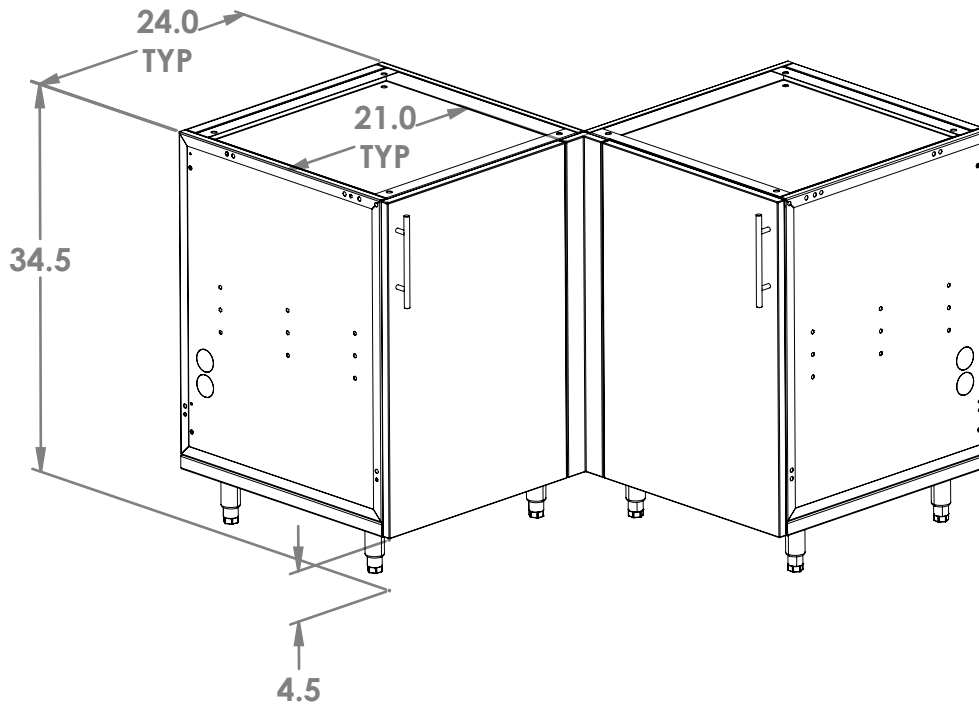
Door Styles:



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IB-(X)-(Y)-(Z)-SNKDDR-(Door Style)

## DEAD SPACE BASE CORNER



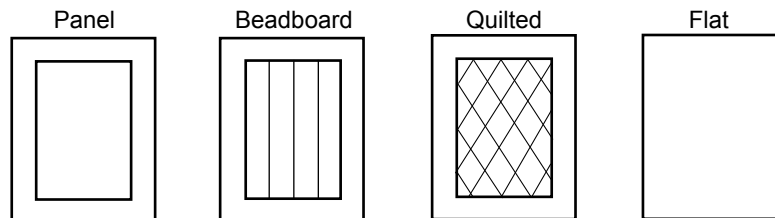
*Example Displayed:  
IB-24-24-36-DDSC-FLAT-LR*

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"   27"
Depth (Y)	24"   28"   34"
Height (Z)*	30"   36"   42"

\*All cabinet heights account for standard 1 1/2" countertop (not included).

\*\* The total width of this cabinet is equal to the width+depth+door clearance spacer.

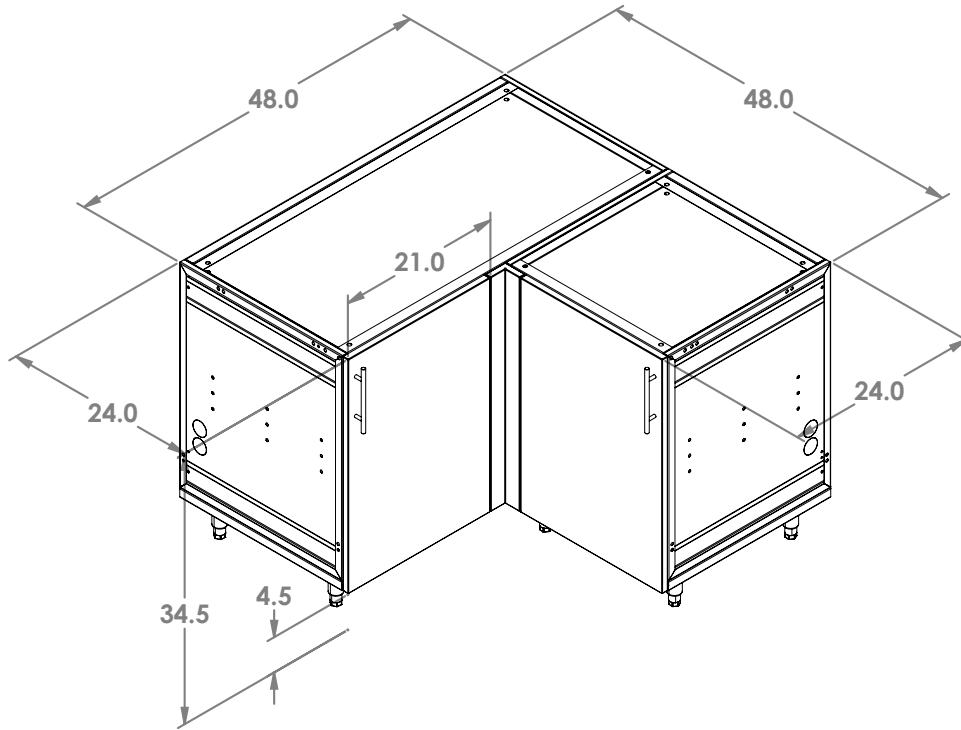
**Door Styles:**



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IB-(X)-(Y)-(Z)-DDSC-(Door Style)-(Handle Sides)

## BLIND BASE CORNER CABINET



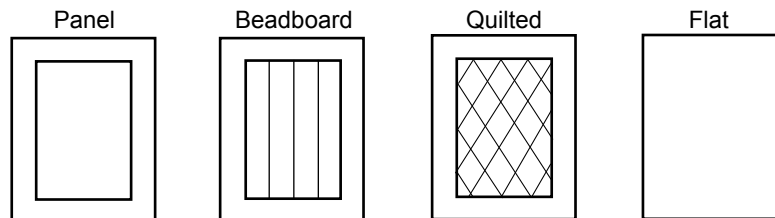
Example Displayed:  
IB-24-24-36-BLDCRN-FLAT-LR

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"   27"
Depth (Y)	24"   28"   34"
Height (Z)*	30"   36"   42"

\*All cabinet heights account for standard 1 1/2" countertop (not included).

\*\* The total width of this cabinet is equal to the width+depth+door clearance spacer.

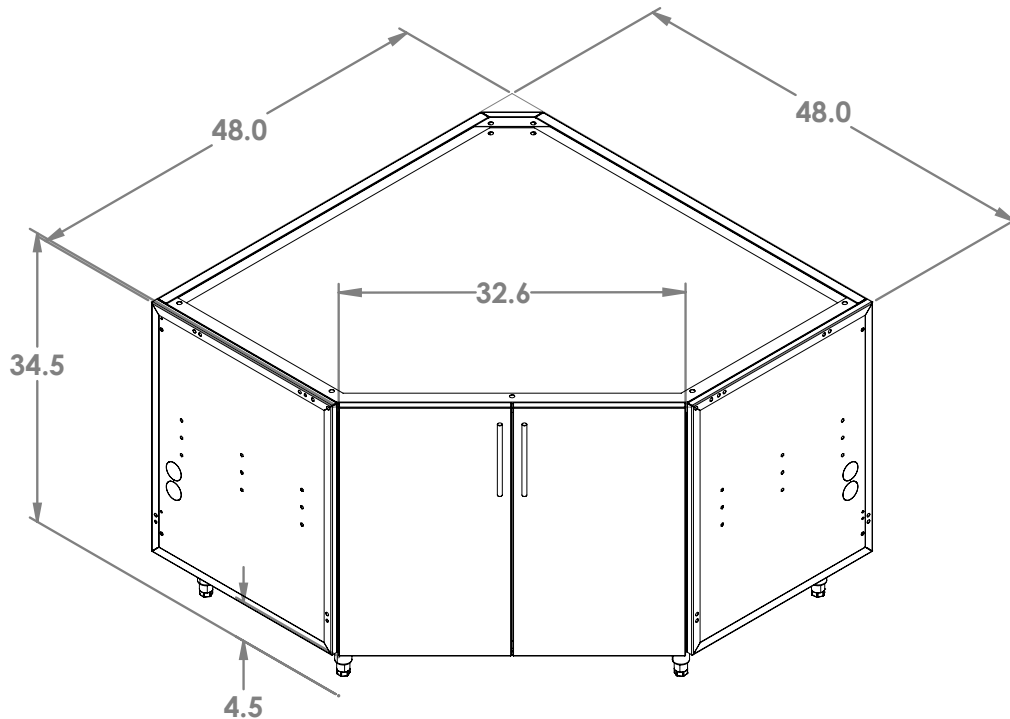
Door Styles:



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IB-(X)-(Y)-(Z)-BLDCRN-(Door Style)-(Handle Sides)

## 45 DEGREE BASE CORNER CABINET



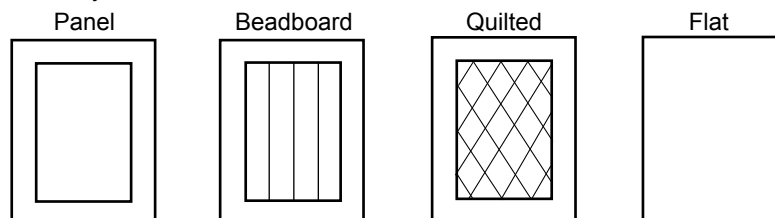
Example Displayed:  
IB-24-24-36-45CRN-FLAT-LR

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"   27"
Depth (Y)	24"   28"   34"
Height (Z)*	30"   36"   42"

\*All cabinet heights account for standard 1 1/2" countertop (not included).

\*\* The total width of this cabinet is equal to the width+depth+door clearance spacer.

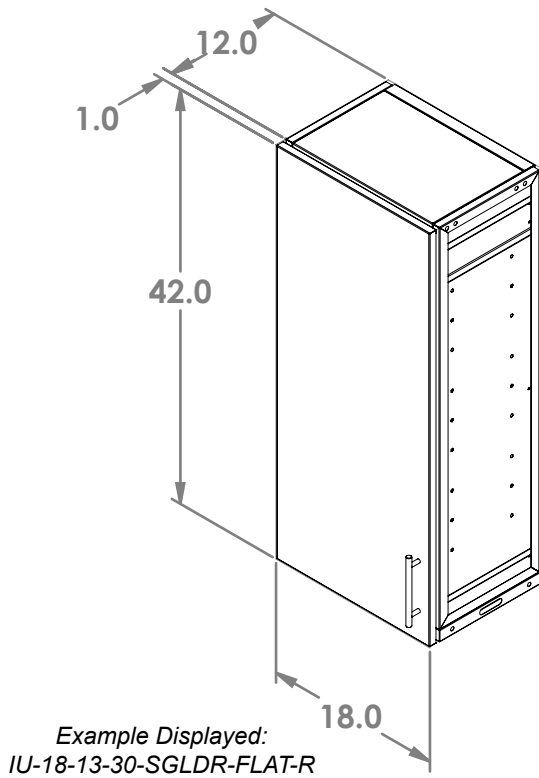
### Door Styles:



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

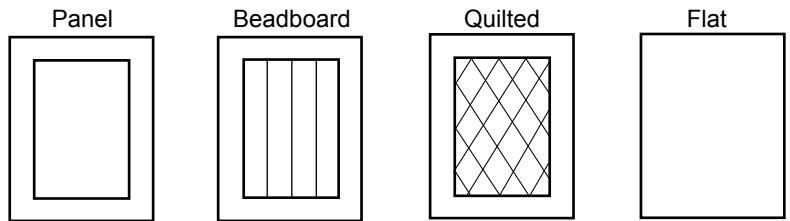
IB-(X)-(Y)-(Z)-45CRN-(Door Style)-(Handle Sides)

## SINGLE DOOR UPPER CABINET



Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"
Depth (Y)	13"   24"
Height (Z)	12"   15"   18"   24"   30"   36"   42"   48"

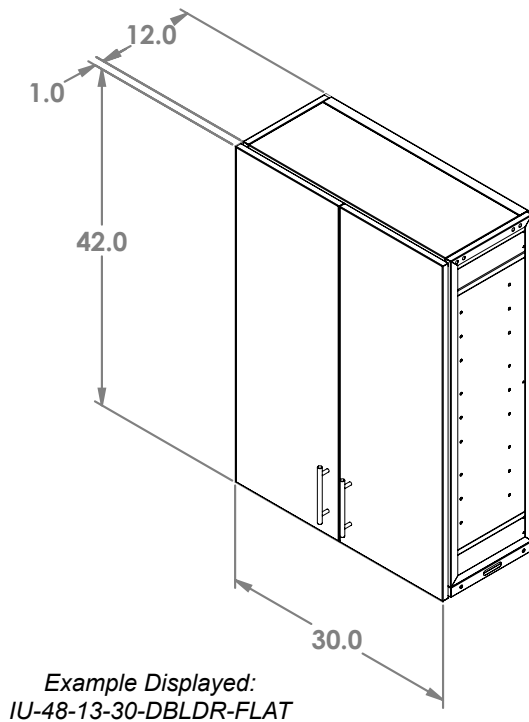
### Door Styles:



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

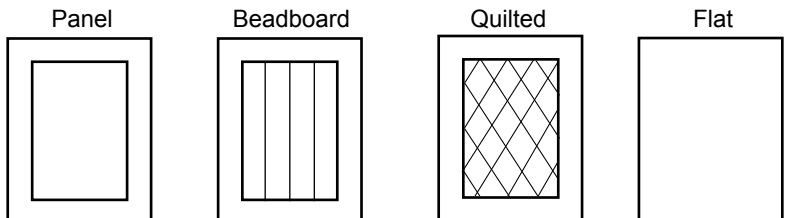
IU-(X)-(Y)-(Z)-SGLDR-(Door Style)-(Handle Side)

## DOUBLE DOOR UPPER CABINET



Available Dimensions	
Width (X)	24"   27"   30"   33"   36"   39"   42"   45"   48"
Depth (Y)	13"   24"
Height (Z)	12"   15"   18"   24"   30"   36"   42"   48"

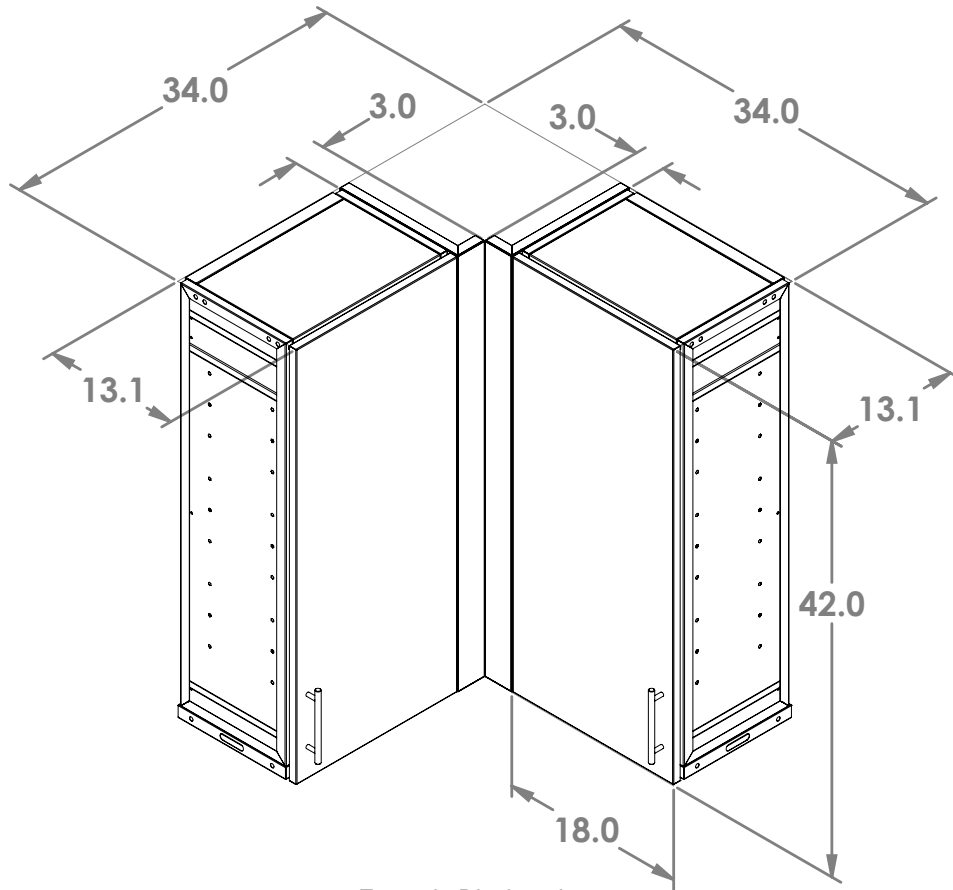
### Door Styles:



Insert Width(X), Depth(Y), Height(Z), and Door Style into parts number:

IU-(X)-(Y)-(Z)-DBLDR-(Door Style)

## DEAD SPACE UPPER CORNER CABINETS

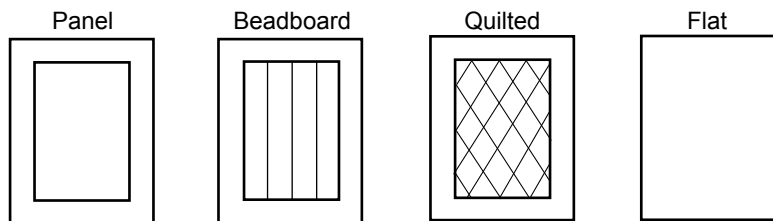


Example Displayed:  
IU-18-13-42-DDSC-FLAT-LR

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"
Depth (Y)	13"   24"
Height (Z)*	12"   15"   18"   24"   30"   36"   42"   48"

\* The total width for this corner unit is the width+depth+door clearance spacer.

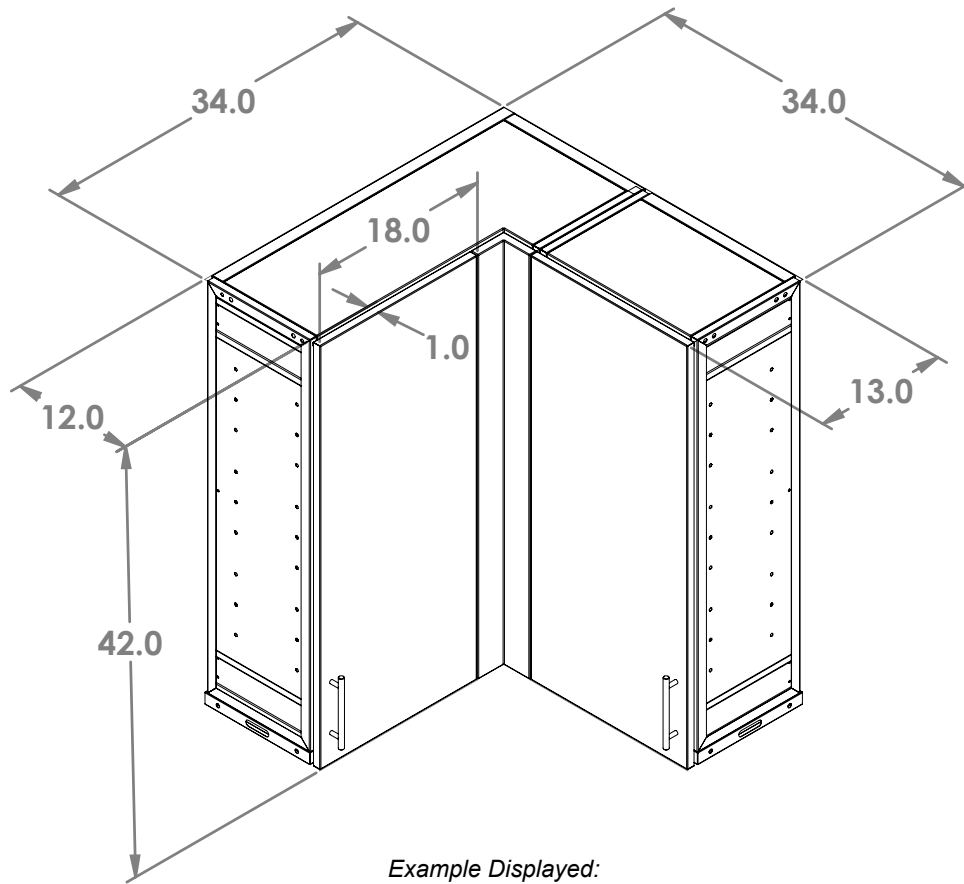
### Door Styles:



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IU-(X)-(Y)-(Z)-DDSC-(Door Style)-(Handle Sides)

## BLIND UPPER CORNER CABINET

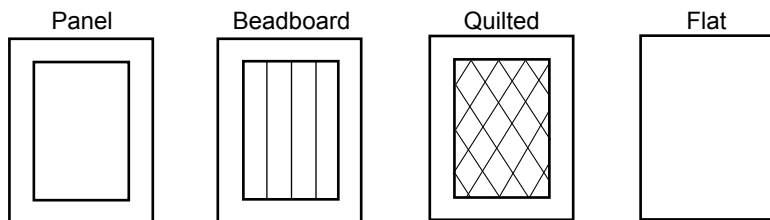


Example Displayed:  
IU-18-13-42-BLDCRN-FLAT-LR

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"
Depth (Y)	13"   24"
Height (Z)*	12"   15"   18"   24"   30"   36"   42"   48"

\* The total width of this corner unit is equal to the width+depth+door clearance spacer

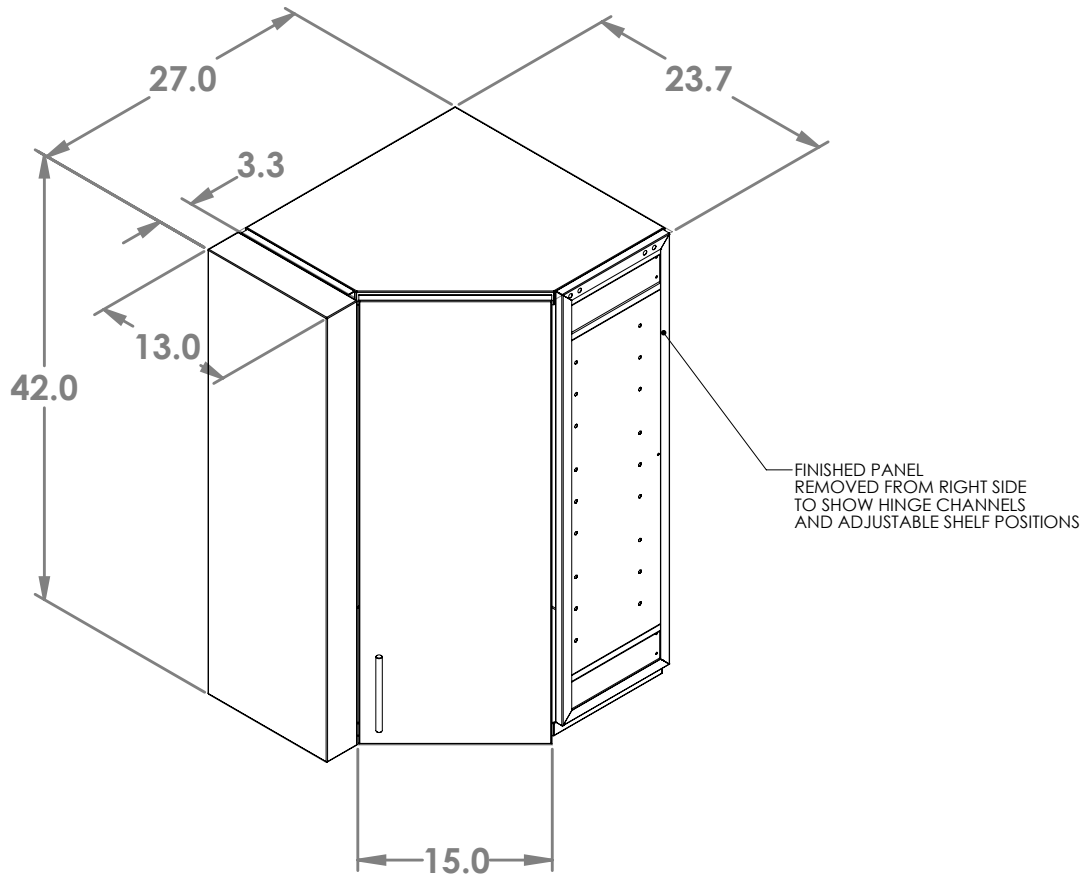
### Door Styles:



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IU-(X)-(Y)-(Z)-BLDCRN-(Door Style)-(Handle Sides)

## 45 DEGREE UPPER CORNER CABINET

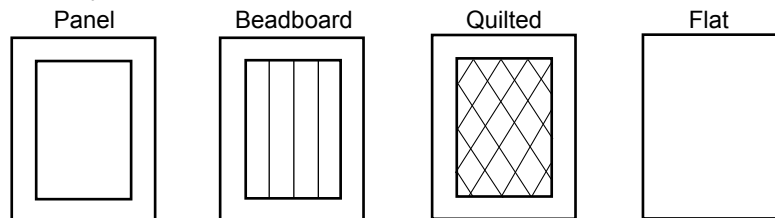


Example Displayed:  
IU-15-13-30-45CRN-FLAT-L

Available Dimensions	
Width (X)	9"   12"   15"   18"   21"   24"
Depth (Y)	13"   24"
Height (Z)	12"   15"   18"   24"   30"   36"   42"   48"

\*The total width of this corner unit is equal to the width+depth.

### Door Styles:



Insert Width(X), Depth(Y), Height(Z) and Door Style into parts number:

IU-(X)-(Y)-(Z)-CRN-(Door Style)-(Handle Sides)

## SPECIFICATIONS

### Materials

#### General Scope

- This specification is provided in order to ensure the manufacture of the highest quality stainless steel casework as required by residential and commercial kitchens.

#### Stainless Steel Materials

- All components of cabinet assemblies shall be constructed from stainless steel materials, including drawer bodies, cabinet walls, cabinet ceilings, cabinet floors, shelves, drawer and door panel assemblies, as well as all hardware – including drawer slides and door hinges. The only exception to this shall be the plastic and/or rubber components necessary to provide bumpers, cylinders, and padding for soft-closing, self-closing, and hold-close mechanisms.
- Cabinets shall be made from 300 series stainless steel, except for door hinges and drawer slides, the materials in these components are outlined below.
- All cabinets shall be made from heavy-duty stainless steel. All components shall be made from a gauge that correlates to its structural requirements and shall not be affected by grade selection.
- The finish of the sheet metal used in fabrication shall be selected based on customer requirement. All fabricated sheet components shall require a #4 brushed finish unless all require a powder-coated finish. In this case, a 2B finish shall be acceptable to mitigate the expense of powder coating processes.

#### Core Material for Door and Drawer Panels

- Drawer and door panel assemblies shall be bonded together via a sound deadening foam stiffener substrate and welded together in each coincident corner thereafter.

#### Cabinet Hardware and Trim Molding

- Decorative Pulls
  - Decorative pull styles and locations shall be in accordance with customers selections based on this company's offerings, constructed from 300 series stainless steel. All pulls shall be attached with 300 series stainless steel fasteners via holes cut prior to fabrication to eliminate distortion caused by drilling holes after fabrication.
- European Style Overlay Hinges
  - Overlay style cabinets shall use European style soft-closing hinges made from 300 series stainless steel materials with small, non-structural components of

## SPECIFICATIONS

plastic and/or rubber needed to produce the soft-closing effect. Hinges shall be attached to doors and cabinet walls via 300 series #8 stainless steel fasteners with either flat (countersunk) or button heads requiring Philips or hex drive. Two screws shall be used to fasten mounting plates to walls and two screws shall be used to fasten hinge bodies to door panel assemblies. Hinges shall offer three dimensions of adjustment requiring Philips or hex drive.

- The number of hinges used on each door assembly shall vary based on total weight of the door and any attachments, coatings, or hardware applied. All doors must have at least two hinges, but doors heavier than 13 lbs. (6.0 kg) shall have 1 hinge added per each 6.5 lb. (3.0 kg) increment of added weight. Wherever possible, the distance between the top and bottom hinge shall be greater than the width of the door.
  - Hinges shall not be welded in any case to ensure maximum on-site adjustability and integrity of hinge strength.
  - Hinges shall be self-closing to eliminate the need for door catch mechanisms.
- **Drawer Slides**
    - All drawer slides shall be fabricated from .039" (1.0 mm) thick 18-4 stainless steel and feature stainless steel ball bearings and springs. Lubricant shall be applied to the ball bearings to facilitate smooth opening and closing during operation.
    - Wherever necessary, small, non-structural components shall be composed of plastic and/or rubber to facilitate the soft-closing, lever disconnect, and hold-close mechanisms utilized therein.
    - Slides shall be heavy duty, full extension, and rated for 77 lbs. (35 kg) per set. For drawers greater than twelve inches tall and/or twenty-four inches wide (or upon request), two sets of drawer slides shall be utilized to accommodate a greater load rating for that drawer. Slides shall feature lever disconnection to facilitate easy drawer removal and installation.
    - Drawer bodies shall be manufactured with the proper clearance from the installation wall to ensure smooth operation of the soft-closing mechanisms.
    - Drawer slides shall be fastened in a manner that allows for easy removal and replacement on-site in the event of a slide failure. Slides shall be attached with 300 series stainless steel #8 hex drive button head machine screws and fixed position stainless steel

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nuts.

- Shelf Adjustment Screws
  - All shelves shall be fastened to mating walls via 300 series stainless steel fixed position nuts and 300 series #10 Philips drive pan head machine screws. Unless required by the customer, no welding of shelves shall be permitted to ensure proper adjustment.

## Assembly and Construction

### Stainless Steel Cabinets

- Scope
  - Cabinets shall be constructed in the style of overlay cabinetry, sometimes referred to as “European Style” cabinetry. When closed, all doors and drawers rest with the back side of their panels flat against any adjacent framing or railing so that minimal framing or railing is visible from a front facing position. A uniform 1/8” reveal (air gap) shall be the only border between cabinet panels of doors and drawers, as well as any finished end panels.
  - Cabinets shall be designed as modular units that can be moved into any position in line without failure as finished side panels may be fastened at any time to any cabinet side wall.
  - All surfaces of every cabinet that come into regular contact with the user shall be smooth and free of burrs, sharp edges, or other defects. Surfaces shall be easy to clean and must not harbor dirt, oil, food, or any other foreign material and must have access and/or passage holes for electrical, plumbing, and ventilation as required.
  - Cabinets shall be designed to standards that allow easy and aesthetically pleasing implementation alongside most under-counter appliances. Therefore, standardized dimensions of doors and drawers shall be constructed within the limits of prominent appliance manufacturers and divisions of variable height dimensions shall be multiples of those limits.
- Gauges
  - Base cabinet floor channels: 14 gauge
  - Door and drawer panels, shelves, walls, floors, ceiling headers and corner brackets, drawer bodies, drawer and door frames, and any other finished panels not mentioned prior: 18 gauge
- Construction
  - All structural frame components including floors and walls shall be constructed with

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welded-in or integral u-channels for maximum rigidity. The width of wall channels shall be 1.25" for rear walls and .800" for side walls to ensure proper spacing of the uniform reveal.

- All structural support ceiling headers shall be one solid piece with singular bends from top down 1.25" with a return bend on the front and hems on front and back to ensure a flat, smooth surface for countertop bonding as well as offer maximum cross-bracing capability and ergonomic cabinet use. Ceiling brackets shall be implemented and fastened to the sides and back walls via #10 300 series stainless steel fasteners in order to maintain high rigidity for shipment, installation, and usage.
- Leveling feet capable of supporting 2,000 lbs. (900 kg) shall be welded in place in all corners of every floor of every base cabinet and shall not be visible from inside the cabinet. Nor shall there be holes inside the cabinet for access to the leveling feet. Access to the leveling feet shall only be available after removal or before placement of the toe kick. Leveling feet shall be welded to the flat, lower surface of the floor channels which shall rest against the bottom surface of the cabinet floor via upper return flanges and subsequently welded in place.
- All walls shall rest on the cabinet floor above the areas in which the leveling feet are resting for inline transfer of support from feet to cabinet wall.
- All cabinet frame and support components shall be flush to one another so that no surface protrudes out and interferes with on-site kitchen/laboratory construction. Any components that may interfere with on-site kitchen/laboratory construction shall not be allowed.
- Toe kicks shall be constructed in a manner that makes them easy to remove or to place into position below the cabinet. Once in position, the space in front of the toe kick and below the cabinet shall be 1.875" deep and 4.5" tall.
- Door and drawer panels shall be constructed of two box-shaped fabricated pieces with the rear frame piece being bonded to a sound deadening foam substrate and the front panel bonded to the opposite side of the same substrate. Both pieces shall have a flange overlap of the  $\frac{3}{4}$ " thick substrate that oppose one another, however, the front panel shall overlap the rear frame as well so that a smooth and rounded appearance is achieved. All gaps between the front panel flange and the opposing rear frame flange shall not exceed .010". All corners shall be welded and polished to maintain the smooth and round appearance in all corners.
- Door and drawer panels shall be easy to remove via push button release hinges or easily accessed machine screws for quick replacement. Welding of hinges and/or

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slides is not acceptable.

- Drawer body assemblies shall be constructed of a single piece of 18 gauge stainless steel in order to allow the formation of integral sides of the main body. All pieces shall be constructed in a manner that allows maximum drawer panel positional adjustment and leaves all exposed surfaces smooth, without burrs or sharp edges, and easy to clean. Upon positioning inside of the cabinet, the drawer body shall be flush with the side wall frame of the cabinet to allow the drawer panel to rest against the wall frame upon closing.

## Durability of Casework

### Base Cabinets

- Base cabinets shall be constructed in a manner that allows maximum strength and rigidity so that the cabinets may support countertops and appliances that may be applied. Base cabinets shall support no less than 130 lbs. (90 kg) per square foot of top surface area at all walls and ceilings. Absolutely no noticeable permanent deformation of walls and ceilings nor interference with function and position of doors and drawers from loads less than 130 lbs. (90 kg) shall be accepted. Whenever necessary, the gauges of walls and tops may be increased to prevent deformation in larger cabinets.
- Leveling feet shall be welded in all corners in a position below the surface where walls and floors meet and shall support 2,000 lbs. (900 kg) at 1.500" of extension of leveling screw without fail.
- All shelves shall support 45 lbs. (20 kg) per square foot of top surface area without permanent noticeable deformation.
- Stainless steel slides shall be used on all drawers and shall incorporate ball bearings, soft-closing mechanisms, and hold-close mechanisms supporting a maximum of 77lbs. (35 kg) per pair.

### Upper Cabinets

- Upper cabinets shall be constructed in a manner that allows maximum strength and rigidity so that the cabinets may support countertops and appliances that may be applied. Upper cabinets shall support no less than 10 kg per square foot of shelf surface area. Absolutely no noticeable permanent deformation of walls and ceilings nor interference with the function an position of doors from loads less than 10 kg shall be accepted. Whenever necessary, the gauge of walls and shelves may be increased to prevent deformation in larger cabinets.

## Cabinet Finishes

## SPECIFICATIONS

- All cabinet components must be cleaned and free of foreign materials prior to assembly. All welded components must be cleaned and free of foreign materials before welding processes and polished and cleaned again after the welding process is complete and before fastening to cabinet assemblies. All surfaces shall be clean and free of foreign materials prior to assembly and cleaned again following final assembly.
- Any special finishes such as powder coating, grain polishing, or surface treatment shall be applied to pertinent components prior to final assembly and after all welding has been performed.
- Cleaning: All dirt, oil, and other foreign materials shall be removed with chemicals that are not corrosive to stainless steel nor to any applied coatings. Upon removal of all foreign materials with cleaning chemicals, surface polish shall be applied in a manner that leaves the appearance of the cabinet smooth, uniform, and aesthetically pleasing. Smudges, streaks, and smears on any exposed surface shall not be acceptable prior to shipping preparation.

## Installation of Cabinets

### Scope

- Cabinets shall be installed in a manner that facilitates the use of all necessary access and/or passage panels/holes and storage areas practically and symmetrically. This is best achieved through careful planning and thorough understanding of all portions of the project that shall interact with cabinets from electrical and plumbing to the end user.
- Please be aware: Sheet metal cabinetry must be made in a facility with equipment specifically designed to cut and bend material that is exceptionally strong and resistant to cutting with common abrasives. Therefore, projects should be planned accordingly to facilitate an installation experience that utilizes the positional adjustments built into the cabinets during the manufacturing process. If this is not possible, please contact the manufacturer immediately to resolve any possible issues with installation before raw materials have been expended and modification without defect is unlikely.
- Please read and understand all installation directions before continuing with installation process.
- All cabinets must be installed level and plumb, with applicable surfaces flush, square, and inline for the entire length of the cabinet line. Leveling feet shall be manipulated to achieve proper contact of mounting surfaces as well as to create a uniformity of cabinet, door, and drawer level. Filler strips may be necessary in locations where cabinets intersect finished portions of the project. These may be supplied by the manufacturer.

### Allowable Variation

- Ceiling level: not more than 1/16" between adjacent cabinets and 1/4" over 10 feet.

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- Door and drawer paneling: a 1/8" reveal between all adjacent panels must be maintained within 1/16".
- Finished paneling to level: 1/4" per 10 feet.
- All other framing to adjacent surfaces: 1/16"

### Base Cabinet Installation

- Position and level all base cabinets and fasten from right to left through manufactured holes each cabinet to adjacent and mating cabinet using provided #10 button head hex drive machine screws.
- Manipulate leveling feet until all cabinets fall within allowable variation described above.
- Manipulate all dimensions of adjustment for all door and drawers until cabinets all function properly (i.e. all soft-closing and hold-close mechanisms) and tolerance for all reveals have been met.
- Fasten cabinets to existing framing or blocking through four existing holes through the back walls of the cabinets. If no blocking or framing exists in areas directly behind the provided holes, then and only then, shall it be advisable to add holes in the back wall of the cabinets for attachment.
- Finally, (if applicable) press (each) toe kick into position by aligning the stainless steel spring clips on the rear of the toe kick with the leveling feet and – while resting the bottom side of the toe kick on the ground floor – slide them toward the leveling feet until they lock into position – the spring clips will snap around the leveling feet. The spring clips are not in the center of the toe kick vertically and must be oriented such that the clips are closer to the cabinet floor than to the ground floor the toe kick is resting on. It is preferable to lay down a thin, non-abrasive cushion on the ground floor and below the toe kick to keep the toe kick from getting scratched during assembly (i.e. a thin sheet of plastic, cardboard, or cotton sheet) – cushion should be constructed strongly enough to prevent tearing upon removal after final assembly.

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### Wall Cabinet Installation

- Use the provided stainless steel wall cleat(s) to position and install cabinet(s). Mark the position of the first screw by locating a usable wall stud and determining the distance from the bottom and either side of the cabinet to the center of the hole position. The location of the line of screws vertically is 2" down from the top of the cabinet and begin 2-3/4" in from each side of the cabinet, with a 1" space between holes. Keep in mind that the wall cleat allows up to 2-1/2" of cabinet relocation from side-to-side to accommodate non-symmetrical wall stud locations.
- Screw in the first wall cleat hole and then use a level to determine the location of the second screw as it intersects the second wall stud with the wall cleat parallel to the floor. Screw into second wall cleat hole and as many studs as are available between the first and second holes.
- Use the integrated cleat on the rear of the cabinet to lock into the installed wall cleat and position side-to-side, making sure that the cabinet is seated as far down into the wall cleat as possible.
- Screw into the wall studs through the holes in the bottom rear of the cabinet, using as many studs as are available.