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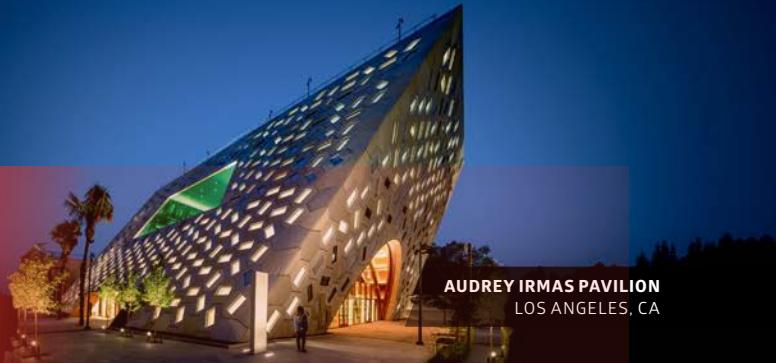
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Cover: The College of the Holy Cross in Worcester, Massachusetts' new Prior Performing Arts Center houses multiple venues to support the education and performance of students. The main attraction in the building is the world class Luth Concert Hall supporting 400 seats and is the college's principal venue of music. See story, page 16.

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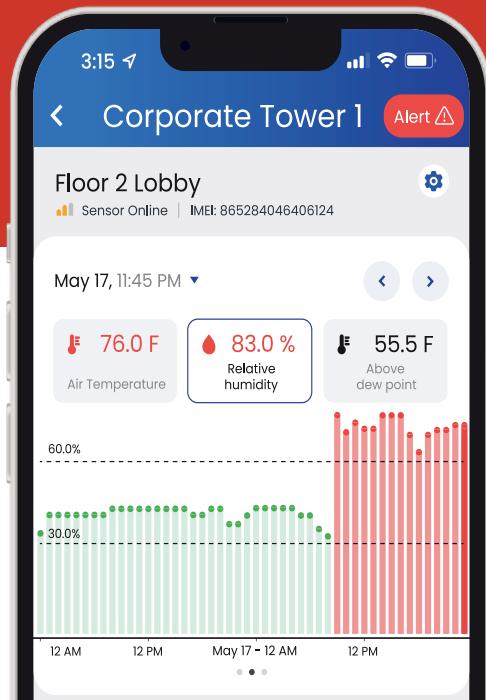
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Inside Info For Design And Construction Professionals

Turn the Page.



If you started singing the Bob Seger song, you're a friend of mine. The concept of turning the page sounds so simple, like we are always afforded new beginnings, forgetting what happened on the previous page. Years ago, we literally took the calendar off the thumbtack, flipped it to the next month, and made a new hole in the wall. Those memories are fun and symbolic, but I'm a bigger fan of my Outlook calendar. There's no turning of pages, just a simple scroll of the mouse and a great reminder that we continuously build on the foundation we laid in previous years.

AWI enjoyed tremendous success in 2024. We officially submitted the last two remaining standards for the canvass process, completing a seven-year journey and bringing closure to the first edition of the ***ANSI/AWI Standards Suite***. Furthermore, the **0620 Installation** and **0641 Architectural Wood Casework** standards went through their first revision cycle. Thanks to this solid foundation, we are exploring new ways to print and distribute the entire suite of standards in 2025.



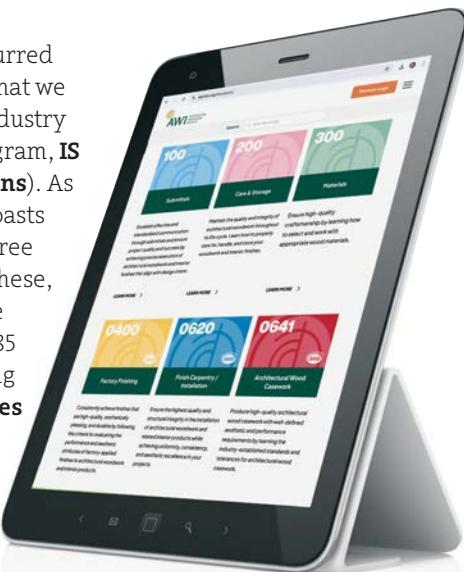
AWI also set a record for attendance at both the **Spring Leadership** and **Annual Convention**. Our Corporate Partnership Program reached a record number of participants in 2024. Additionally, a new **Community Forum** and database were rolled out, offering even more capabilities for our membership to interact.

Membership Growth

Our manufacturing and industry membership hit 997, QCP increased to over 600 licensees, and our supplier member retention rate reached an **all-time high of 93%**.

And all of this occurred in the same year that we launched a new industry credentialing program, **IS (Industry Solutions)**. As of December, IS boasts 572 users in just three short months. Of these, 51 individuals have earned a score of 85 or higher, awarding them the **Principles of Woodworking Credential**.

So, why highlight all these impressive numbers and accomplishments? Because



Join In The Success.

If, after reading the last couple of paragraphs, you're thinking, "That wasn't me; I didn't participate in 2024 with AWI or I have no clue what CODBS means." Don't worry! Email us, call us, or head to our website. There are so many ways to connect and experience the value

of your AWI membership. But just like that gym membership you signed up for on January 1st, you must participate to get the full benefit of your investment.

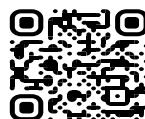
Commit today to making the most of your AWI benefits in 2025. There's something for everyone. While everyone has their own favorites, you won't know which ones are yours until you try them all. I am honored to serve this community and enjoy being a "wood nerd" among friends. This industry is filled with great people! Come experience AWI to the fullest in 2025.

Happy New Year,



Doug Hague
AWI CEO

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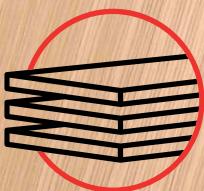
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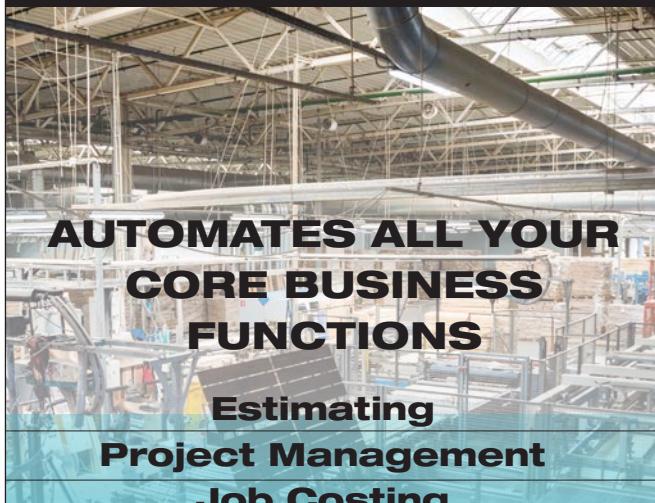
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— Robert Luttrell, Luttrell Architectural Woodworks, Inc.





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Lyrical Design.

A photograph of a modern performing arts center's interior. The foreground shows rows of dark grey theater seats facing a stage. The stage is made of light-colored wood and has a curved, cantilevered section over the audience. The walls are also made of wood and feature vertical slats. In the background, there is a balcony level with more seating and a complex steel and glass structure above it.

College Performing Arts Center
Houses Multiple Venues.



The College of the Holy Cross in Worcester, Massachusetts, is a highly selective, undergraduate liberal arts college renowned for offering a rigorous, personalized education in the Jesuit, Catholic tradition. Its new Prior Performing Arts Center houses multiple venues to support the education and performance of students. The main attraction in the building is the world class Luth Concert Hall supporting 400 seats and is the college's principal venue of music.



at a glance

AWI MANUFACTURING
MEMBER:

Millwork One Inc.

LOCATION:

**Cranston,
Rhode Island**

ESTABLISHED:

1989

FACILITY:

80,000 square feet

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The 84,000-square-foot, \$110-million facility was designed by New York-based Diller Scofidio + Renfro (DS+R), a renowned design studio whose practice integrates architecture, the visual arts, and the performing arts. The building is named for lead donor and alumnus Cornelius B. Prior, Jr., whose cornerstone gift is the largest gift in support of the arts that Holy Cross has received.

Wood is an essential element in a performing arts space and was one of the top considerations when designing the space says Joseph Buduo from Holy Cross and we wanted wood elements incorporated into every space within the building. The architectural woodwork for this quality-certified project was fabricated by Millwork One Inc., an AWI member firm located in Cranston, Rhode Island.





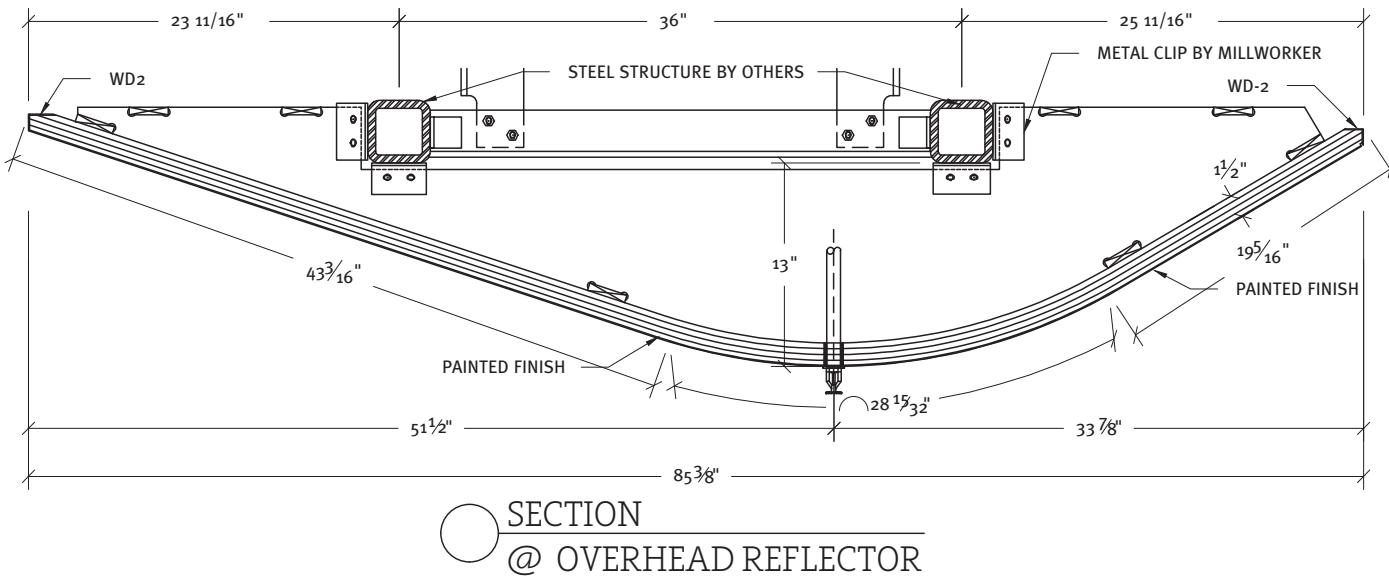
Four Pavilions

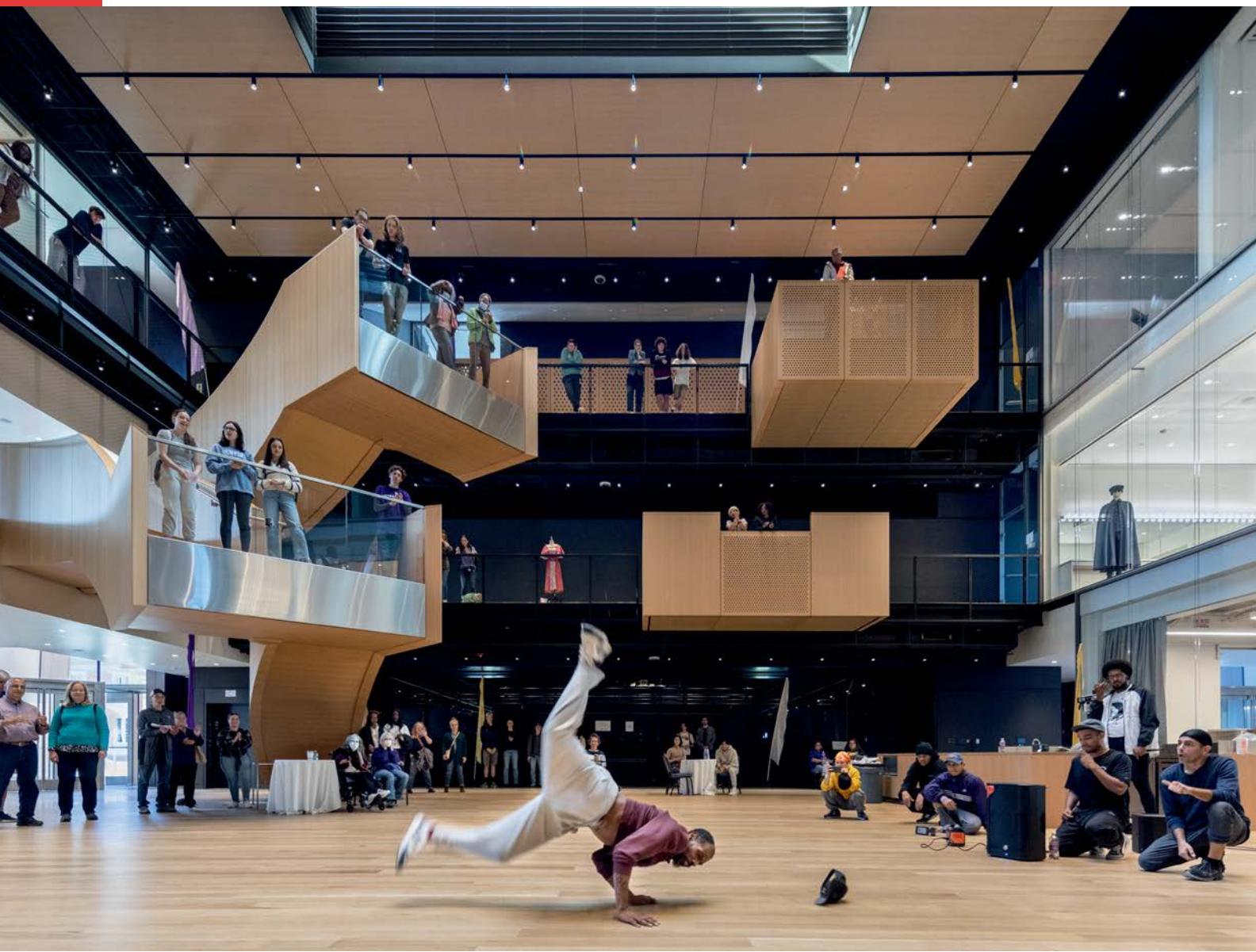
Primary objectives, reports Miles Nelligan of DS+R, were that it was designed to be an incubator for

multidisciplinary learning grounded in the performing and visual arts for students from all academic disciplines; and for the Center to gather

existing vectors of campus circulation at its heart: the Beehive. Around this central space the programs are divided into four pavilions:

the Multipurpose Theater for opera and music; the Studio Theater for drama; Art/Media; and Practice/Production.





The Beehive acts as a visible connective tissue between the public program and the student productions, allowing back-of-house functions to always activate the building. A flexible space with a cafe that supports creative collaboration, the Beehive includes a shared multimedia teaching space for electronic music and musical composition courses, sound recording, sound editing, and video and film editing as well as collaborative workspaces and multipurpose rehearsal spaces.

The informal, hackable nature of the Beehive turns it into a creative playground for study and performance for all students irrespective of their majors. Like a stage, the interior materials combine both the raw and refined: an exposed dark steel technical infrastructure zone rings the space. The steel stands in contrast with the rich woods for the stairs, bars, seating, and student collaboration zones. Simple “building-block” movable furniture allows students to create a performance space for spontaneous events.

Luth Concert Hall is a 400-seat convertible concert hall and proscenium theatre with a full fly tower that serves as the college's principal venue for symphonic music, chamber music, jazz, as well as opera, musical theatre, and dance. The auditorium is designed to be intimate for both smaller audiences for lunch time concerts and larger audiences for premier events. The auditorium walls feature custom parametrically designed concrete diffusion panels.

Boroughs Theater is a 200-seat fully flexible studio theatre for drama that features a 52-foot operable wall that connects the theater to the Beehive. The Media Lab opens onto the Beehive, a shared multimedia laboratory and performance space for digital music, sound and video editing, film, lighting and set design.

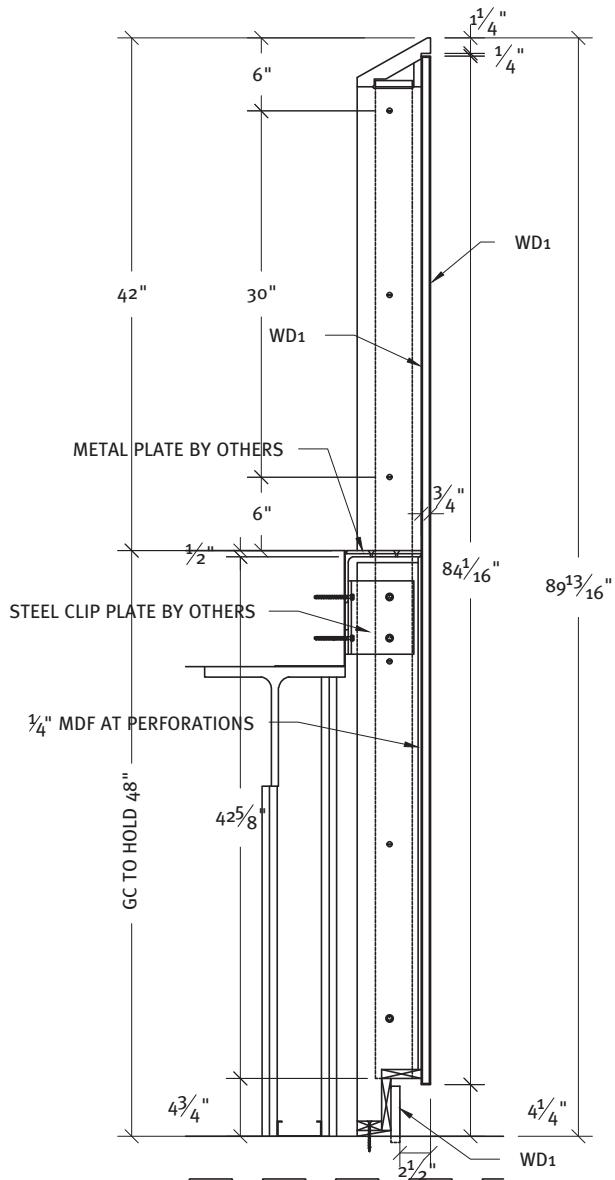
The Iris and B. Gerald Cantor Art Gallery, relocated from its former location, has been expanded to accommodate a variety of interdisciplinary exhibits and increased exhibition and storage space. The

rehearsal dance studio can be reconfigured as an event space that connects to an outdoor, rooftop event space with sweeping views of Worcester and The Blackstone Valley. It includes a small ensemble rehearsal

and live recording room.

Production spaces including a scene shop, costume shop, recording studio, lighting and set design study, and multi-use practice rooms are visible next to refined performance spaces

and the white box gallery, revealing the process of artistic output to the campus community and ensuring that the house never goes dark.



SECTION
@ WALL CAP



Harmonious Woodwork

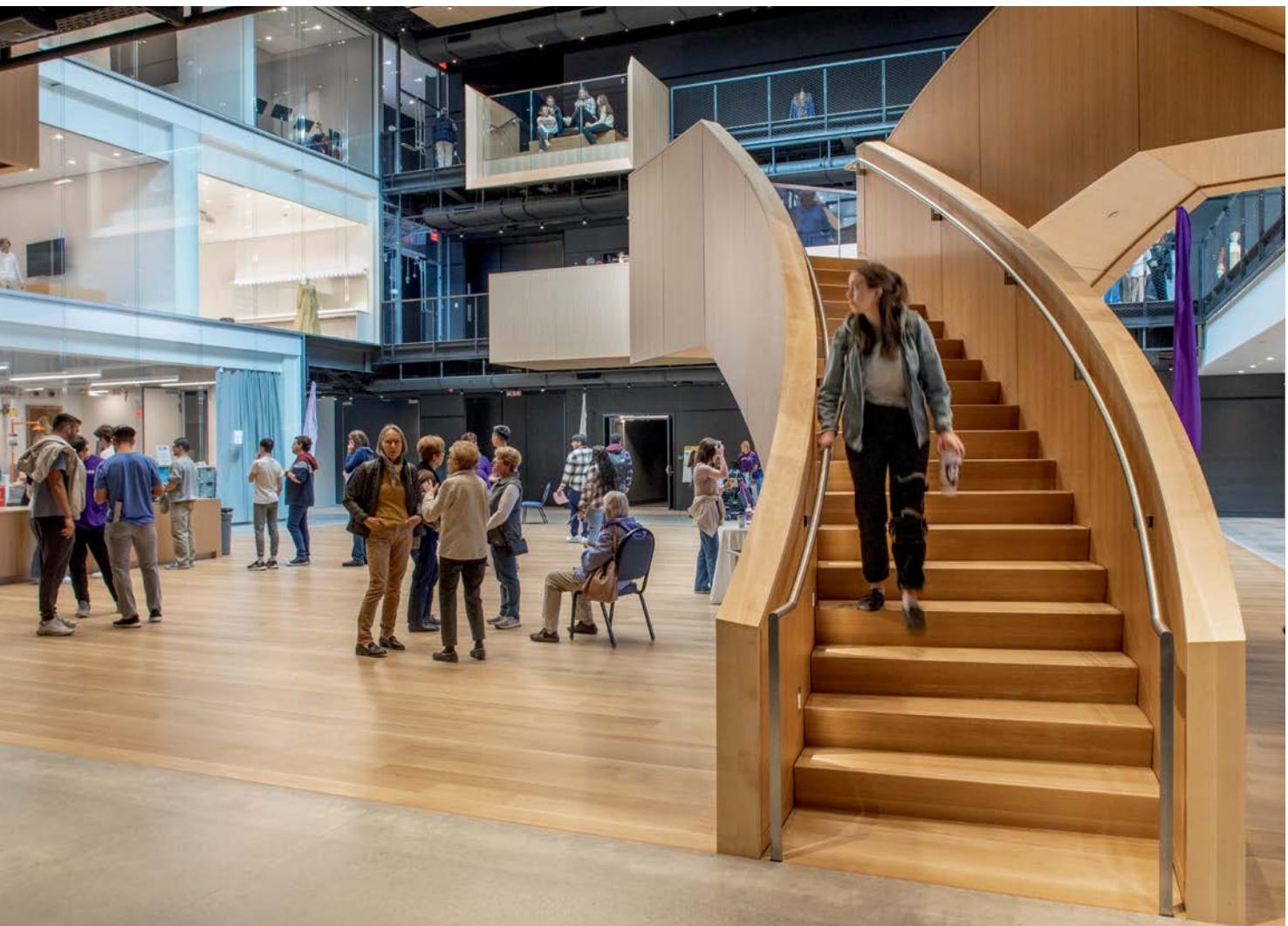
According to John Mello of Millwork One, the firm produced the curved double cantilevered stair in the Beehive which was a complex three-dimensional form, with low tolerance and high live load deflection. "We had to accommodate variances in the rolled, curved stringers and model the stair to be able to individually template each panel. The corner reflector panels in the proscenium theater, dubbed the "potato chips", were

delivered to the contractor as digital 3D models and required experimentation for fabrication in vacuum forming to find the best technique to fabricate a panel that did not require an increase in thickness through the twist to maintain design intent," he explains.

The radius wood paneling in the Luth Concert Hall was one of the most challenging on the project, he notes. "The wood panels were not only radius in multiple directions but flipped over at the back of the room exposing the

“ Our plant employs streamline data systems from engineering to manufacturing, and lean manufacturing procedures for a cost-efficient production stream utilizing multiple pieces of computerized equipment to provide timely delivery of product. ”

— John Fish, President, Millwork One Inc.





opposite side.

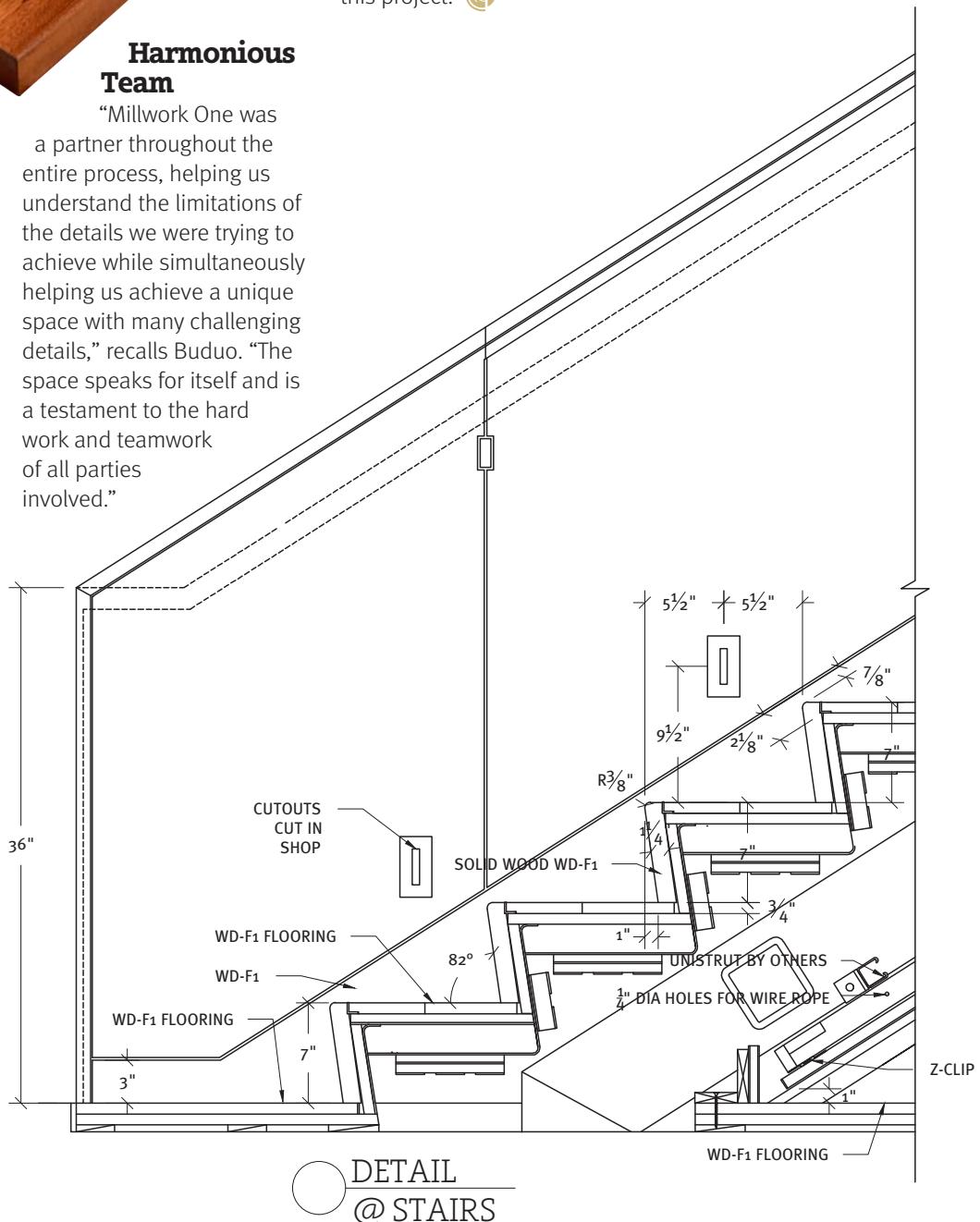
Millwork One engaged early in discussions with DS+R on fabrication, veneer flitch selection, tolerances, and installation to ensure that the final product exceeded design intent. Aspects of the project were delivered to us as digital 3D control surface geometries that needed to be remodeled into fabrication files. Multiple design assist meetings were undertaken via zoom during the pandemic to review the proposed fabrication in three dimensions and to troubleshoot issues."

Makore was chosen for the proscenium for its grain structure and warmth, says Nelligan. "A flitch from a single log was chosen and a deep search had to be undertaken to ensure it was long enough and had enough quantity to do the complete theater shell. Anigre was chosen for the Beehive for its light, slightly warm with a grey undertone color and straight grain."

Mello says, "Millwork One had a great working relationship on this project with the architect. That relationship was one of the major factors that contributed to the success of this project." 

Harmonious Team

"Millwork One was a partner throughout the entire process, helping us understand the limitations of the details we were trying to achieve while simultaneously helping us achieve a unique space with many challenging details," recalls Buduo. "The space speaks for itself and is a testament to the hard work and teamwork of all parties involved."



PROJECT:
Holy Cross Performing Arts Center
Worcester, MA

OWNER:
College of the Holy Cross
Worcester, MA

WOODWORKER:
Millwork One Inc.
Cranston, RI

ARCHITECT:
Diller Scofidio + Renfro
New York, NY

GENERAL CONTRACTOR:
Dimeo Construction Company
Providence, RI

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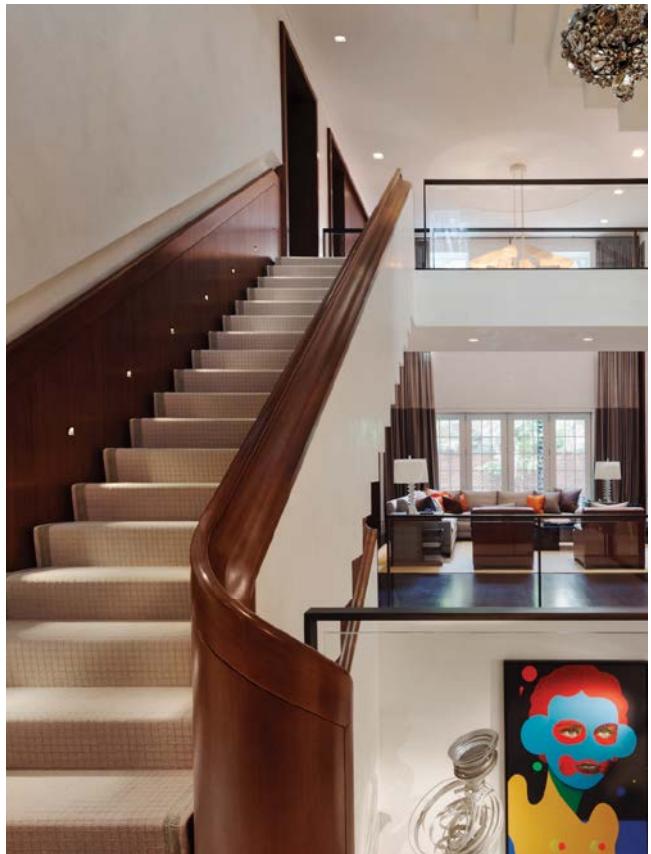
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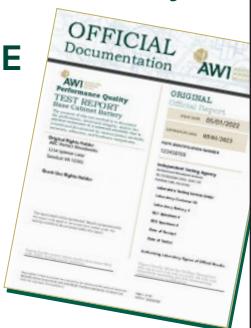
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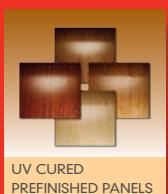


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RWE Clean Energy, a subsidiary of RWE Group, is a top tier renewable energy company in the United States. With more than 15 years in the U.S. renewables business, the company has an outstanding track record in developing, constructing and operating renewable energy facilities. RWE Renewables, which develops and operates renewable energy plants, has signed a 69,000-square-foot office lease at Centro, a mixed-use development in Austin, Texas, that is owned by locally based investment firm Riverside Resources. A quartet of merchandisers and restaurants also recently signed leases to occupy the development's 15,000 square feet of retail space.





Progressive Office.

Energy Company Doubles Office
Space with Innovative Design.



The newly renovated office occupies two floors in Centro Austin on the city's east side, which doubles its current office capacity to accommodate its growing employee base. Design of the space was done by Abel Design Group of Austin. Architectural woodwork for the project was fabricated by ROOMI Group, an AWI member firm located in Houston.

Design Objectives

"As a company, RWE is honest, transparent, and open," notes Laura Evans, associate principal of Abel Design. "They are continuously progressing towards more sustainable energy sources by aligning themselves with people and companies who genuinely believe in their initiatives." When moving to the US, she continues, their goal has been to legitimize and differentiate themselves to future clients and employees. Their goal to attract and retain diverse talent requires a variety of mindful elements within the office.

After strategic visioning and programming with the local RWE team, Abel Design Group developed a mood board to graphically illustrate the concept of biophilic progression, she explains. "Biophilic is sustainability as a reoccurring theme when it comes to the mission behind RWE. Their commitment to the planet has been a driving factor in the company's ability to employ altruistic individuals. By providing a healthy work environment they can increase employee recruitment, retention, and satisfaction within the workplace. Progression because since RWE's inception, they have led the way in the evolution of energy."

The space exudes an inviting sense of warmth and transparency, Evans says. "We incorporated glass, heavily weighted furniture, implied boundaries, and natural materials to set the tone of the office. Thoughtful curves layered with biophilic textures bring comfort to the space while maintaining a clean, neutral, professional environment that appeals to all demographics."

As you progress through the design, a variety of mixed-use spaces allows employees flexible working conditions. While helping companies transition back to the office after years of remote work, there has been an increased demand for meeting and ancillary spaces that provide employees with alternate work modes. By incorporating ancillary hubs near circulation paths, employee interactions can naturally take place from the focused work areas, she notes.

at a glance

AWI MANUFACTURING MEMBER:

ROOMI Group Corporation

LOCATION:

Houston, Texas

EMPLOYEES:

236

Licensed
QCP Manufacturer

Warm White Oak

This large premium grade project held several key pieces for ROOMI Group to showcase our attention to detail while working with curves and angles utilizing veneers and lumber, explains Faisal Hussain. "The floating staircase between the two floors is a masterpiece of design. ROOMI was provided with the metal structure and our scope of work involved taking the structure, wrapping it with several layers of MDF with overlapping joints to create the curves on the inside and outside. The underside, cap and pocket for the handrail were all fabricated, primed and installed by



WHITE OAK

ROOMI. The final piece of the puzzle was all the veneer paneling and hardwood handrail in a complex radius. The effort to take the raw structure to a finish condition was over three months long and afforded 15,000-man hours."

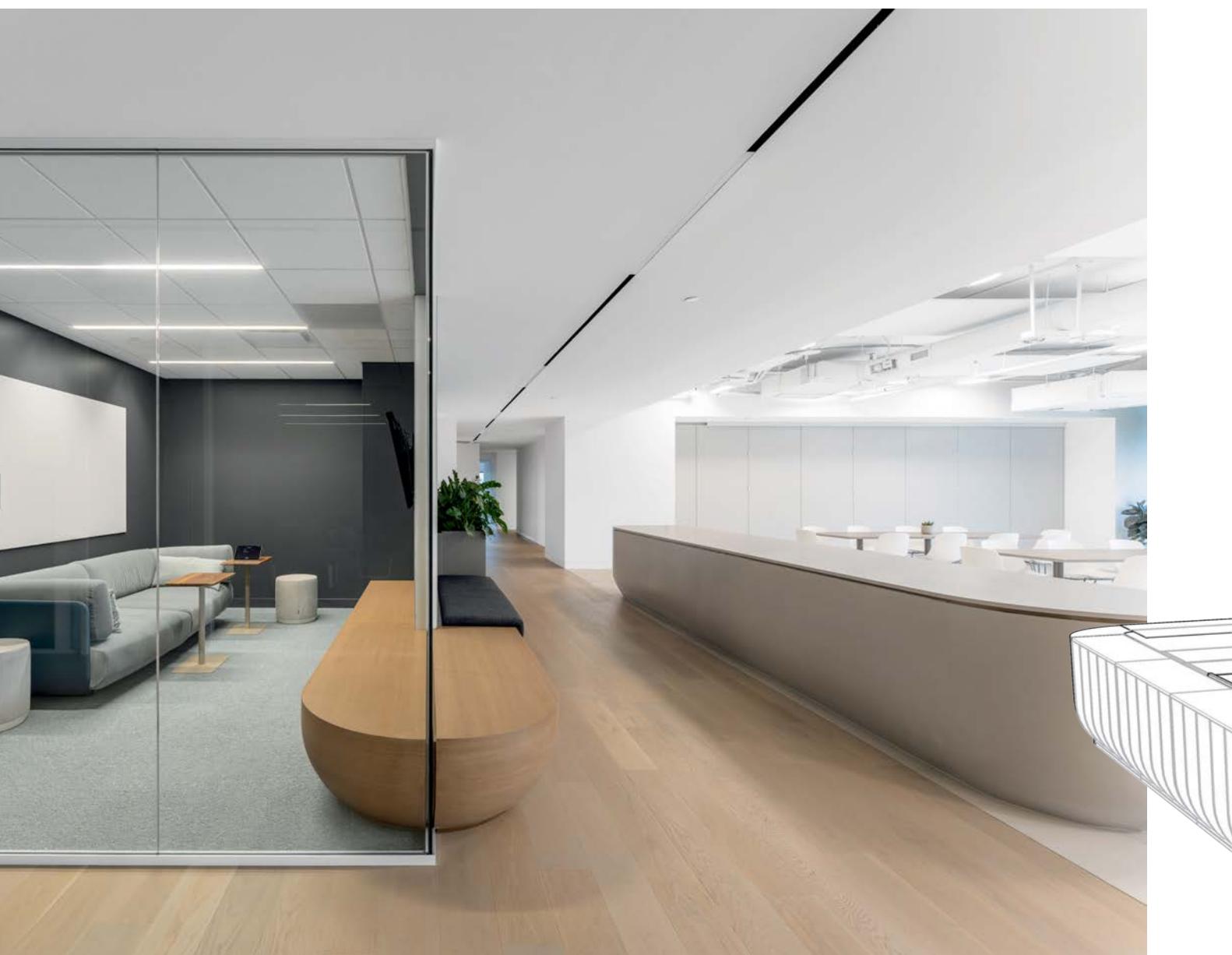


Once we established the radius work on the underside, we were then focused on creating the woodwork panels with a hardwood handrail shaped to the curvature and design, he continues. "All the panels were slip matched with vertical graining to give a monolithic appearance. Each panel was scribed perfectly in the field and created a near seamless appearance."

The final element of the stunning staircase was the handrail which was doweled, glued and clamped on site to the panels for a flush finish. The staircase shows a seamless white underside wrap with compound curves and angles to create a transition to a finished wood interior which is completely radiused with less than 7% straight panels. Just on the staircase, ROOMI installed nearly 18,400 square feet of layered MDF and HDF to create the shell and harvested nearly 7,000 square feet of wood veneer.

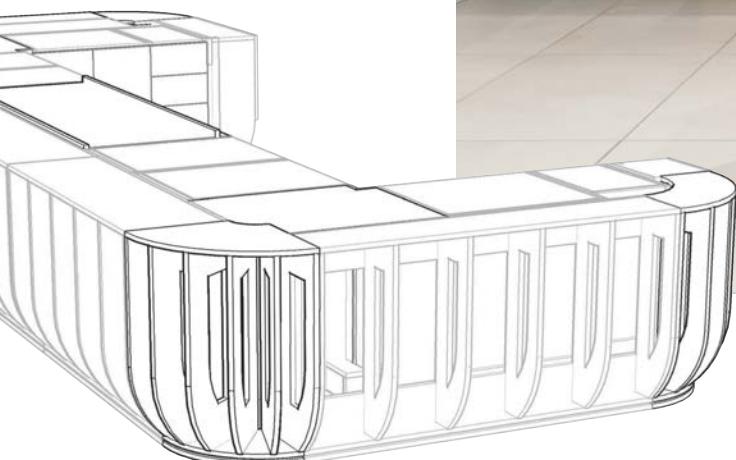
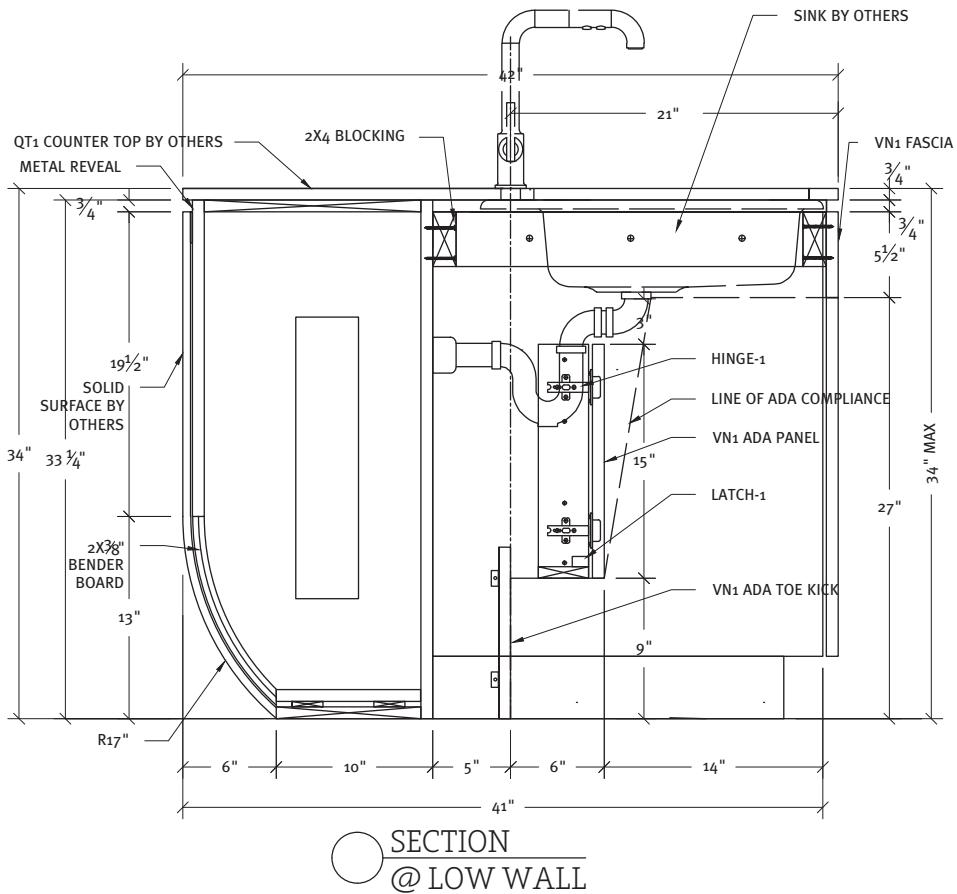
“We not only have simple, ready-to-implement solutions for almost every concern, we have the track record to prove it. And, if you bring us something new, our engineers would love to work with you to find the solution.”

**– Faisal Hussain, Principal/CEO,
ROOMI Group Corporation**



"In addition to the staircase, ROOMI built several custom seating elements which also carried the curved theme on the upper floor, and custom furniture pieces with a compound radius which tapers in as it nears the floor with horizontal veneer graining at key rooms as a seating element," Hussain says.

The project required a natural soft grain presence in the woodwork and furniture pieces. Keeping in line with the clients' business model of clean energy, ROOMI utilized American White Oak, harvested with a tight grain quarter cut selection with zero cross flake. The entire project has several premium units including furniture pieces. "Oak veneer was further muted using a filled finish to create a true furniture grade product. The design required a mix of horizontal and vertical grain pieces. All end graining was essential in creating the unique boat like seating elements, while the vertical graining was slip matched to create a subtle shift in the final woodwork panels," he adds.

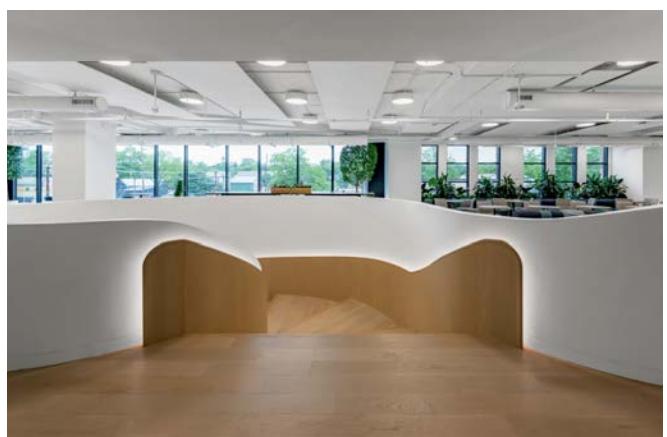


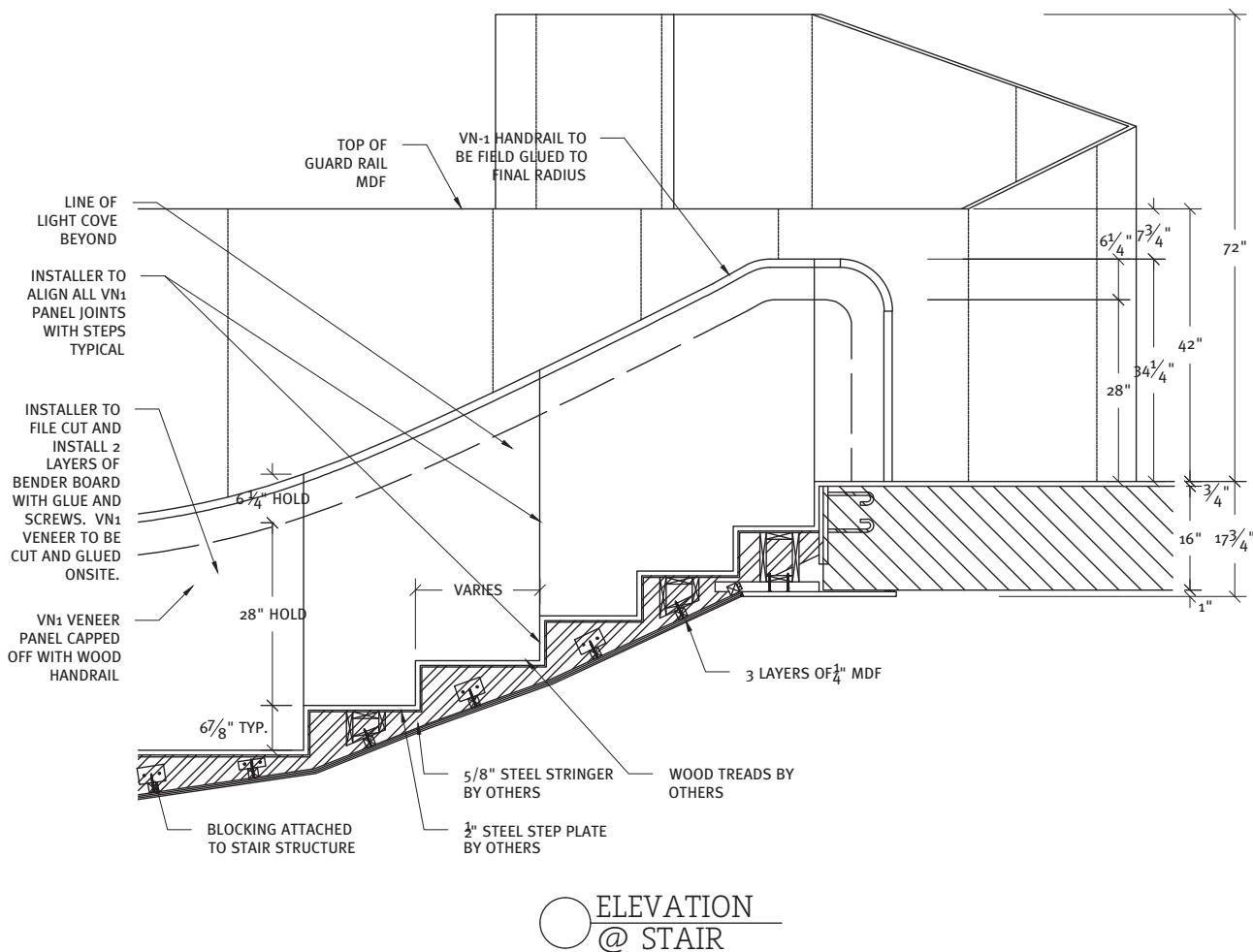


Walnut is used in key locations to add visual contrast and additional warmth to the space. The project also utilized custom metal finishes at all the planters and open area elements. The color and hue of the coatings on the metals were developed by ROOMI to complement the design.

Collaborative Effort

A lot of the detailed elements on this project were created through collaboration and coordination of multiple trades and skillsets, notes Evans. “There was careful detailing and scheduling that went into each monumental design element. We also ran into challenges regarding





which materials were needed to create the curved elements throughout the project such as the banquets, stairs, catering islands, and feature walls. The materials chosen needed to be able to be installed correctly and cleanly – meeting the design criteria – while also withstanding the test of time.”

The entire team had multiple calls throughout design and construction to flush out miscellaneous details, continues Evans. “ROOMI was careful to ask questions regarding our design intent, bring up potential issues, and help us come to the best solution that would not compromise

the integrity of the materials. With this being such a unique form, we trusted their millwork expertise to bring the vision to reality.”

It is rare to build such intricate work on such a grand scale, but to do so in an open collaboration is a true stroke of good fortune, echoes Hussain.

“The team was very gracious and welcoming of our suggestions, insights, and abilities. In a word, it was a true partnership of respect and trust. The success of this project would not be possible without the leadership by the general contractor or the flexibility of the designers. 

PROJECT:
Offices of RWE
Clean Energy
Austin, TX

PROJECT OWNER:
RWE Clean Energy
Austin, TX

WOODWORKER:
ROOMI Group
Corporation
Houston, TX

DESIGNER:
Abel Design
Group
Houston, TX

GENERAL CONTRACTOR:
Harvey Cleary
Builders
Houston, TX

PHOTOGRAPHER:
Andy Phan
Houston, TX

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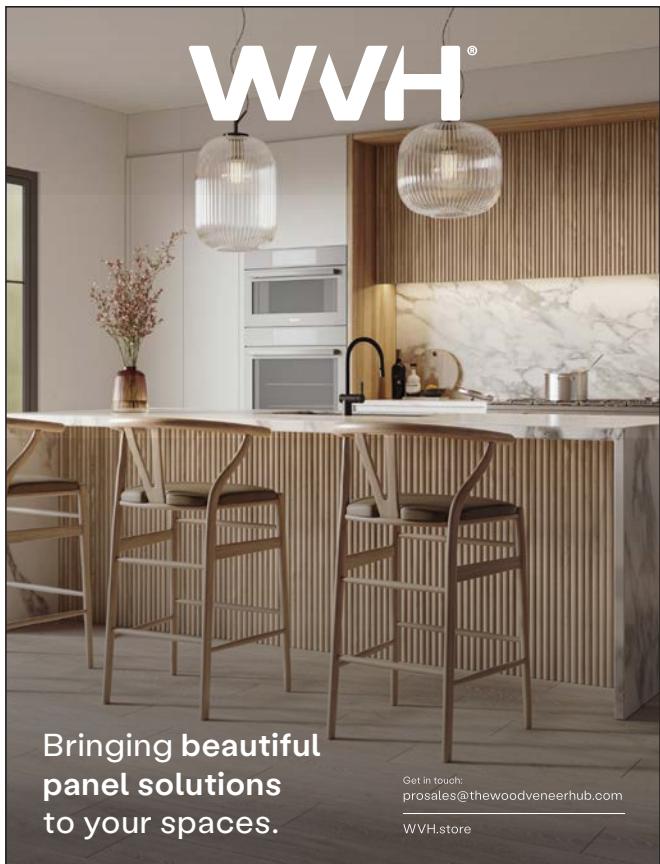
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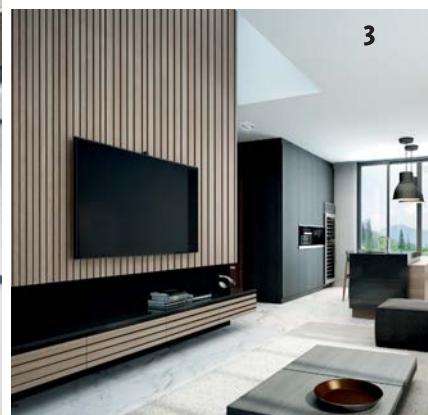


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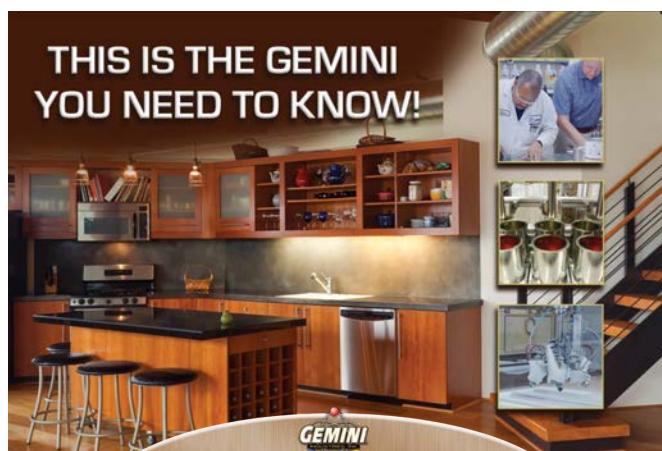
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Conservancy Center.

Michigan Land Alliance Expands
Headquarters Facility.





f

or more than three decades, the Grand Traverse Regional Land Conservancy (GTRLC) has protected and cared for the region's natural, scenic, farm and forest lands. Fully accredited by the Land Trust Alliance, the Conservancy, headquartered in Traverse City, Michigan, is a 501(c)3 non-profit organization with its own by-laws, policies, board, budget and staff.





With the support of individual donors, foundations and volunteers, and the partnership of local, state, and federal agencies, GTRLC has protected more than 47,000 acres of land and 155 miles of shoreline along the region's rivers, lakes and streams. The Conservancy focuses on land conservation efforts that protect crucial wildlife habitat and corridors, critical watersheds, unique high-quality farmlands, valuable forestland and ecologically significant dunes along Lake Michigan's beautiful and endangered shore.

Land is protected in several ways: by working with landowners to permanently protect private land through voluntary conservation easements; by acquiring high-quality natural lands by purchase or donation to create Conservancy owned nature preserves, which are open to the public; by assisting local units of government in creating or expanding public parks and natural areas that result in enhanced public access to nature and improved recreational opportunities; and by providing technical assistance to local units of government with the administration of farmland protection programs.

at a glance

AWI MANUFACTURING MEMBER:

Strata Design

LOCATION:

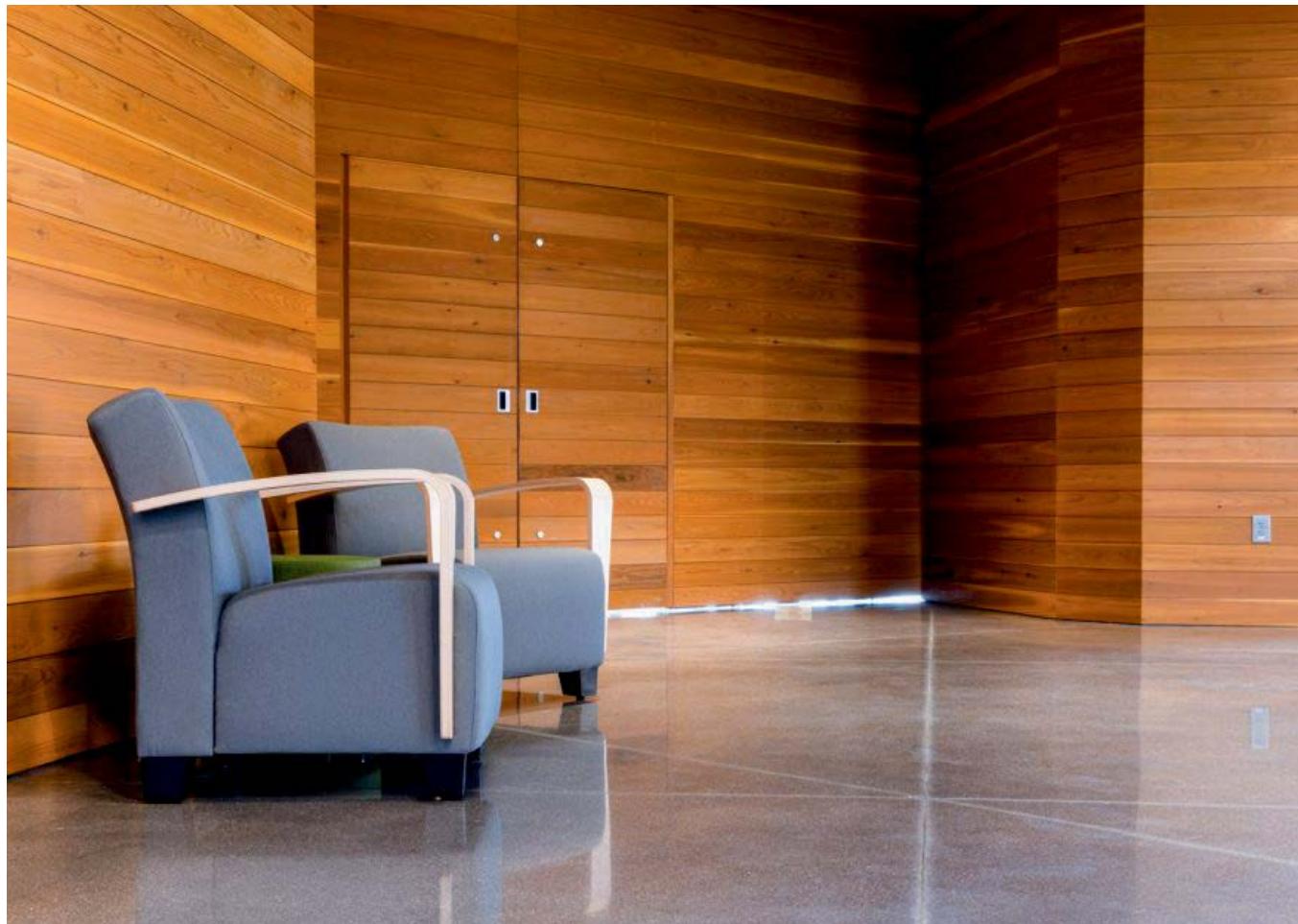
**Traverse City,
Michigan**

ESTABLISHED:

1988

**Licensed
QCP Manufacturer**

GTRLC land protection experts use a variety of conservation tools to protect significant natural and working lands. The stewardship team documents natural and man-made features on protected land, monitors over 300 conservation easements and maintains 50 nature preserves and sanctuaries. The fund development and outreach teams creatively build relationships with individuals and foundations to secure the resources necessary to protect water quality, natural lands, working lands, scenic views, and places where people can enjoy nature. On every level, its work is supported by hundreds of volunteer colleagues.



“Strata Design is not just about design; we excel in executing projects with precision and flexibility, ensuring we meet all customer needs comprehensively.”

– Chris Collins, Senior Project Manager, Strata Design

Headquarters Re-do

When GTRLC decided to build an addition to its existing headquarters facility, Environment Architects, Traverse City, Michigan was commissioned to handle the project. Architectural woodwork for the project was fabricated and installed by Strata Design, an AWI member firm located in Traverse City.

The addition is approximately 16,000 square feet along with several smaller support structures. The renovation cost about \$10 million and took three years from conception to completion.

The primary design objective, according to Ray Kendra AIA of Environment



BIRCH

Architects, was to create a functional, healthy and flexible workspace integrating numerous sustainable and biophilic design principles. This was achieved, he says, “by using large areas of glass bringing in natural light and views, and providing natural ventilation, and use of substantial natural wood elements. Styling cues include modern lines maximizing spatial height to views and creating a low profile in landscape.”

The Woodwork

According to Chris Collins, senior project manager at Strata Design, the woodworking manufacturer produced the custom reception desk with waterfall countertops, floating shelves, all casework including copy center, workstations, collaboration areas, kitchen, break room, bookshelves and built in shelving, and custom TV shrouds with retractable doors.

Materials used on the project, reports Collins, were book matched Birch veneer and hardwood finished clear for open bookcases; Dolkien edge banding for a unique look on laminate doors; and Corian Artista Dust, and several Wilsonart laminates.



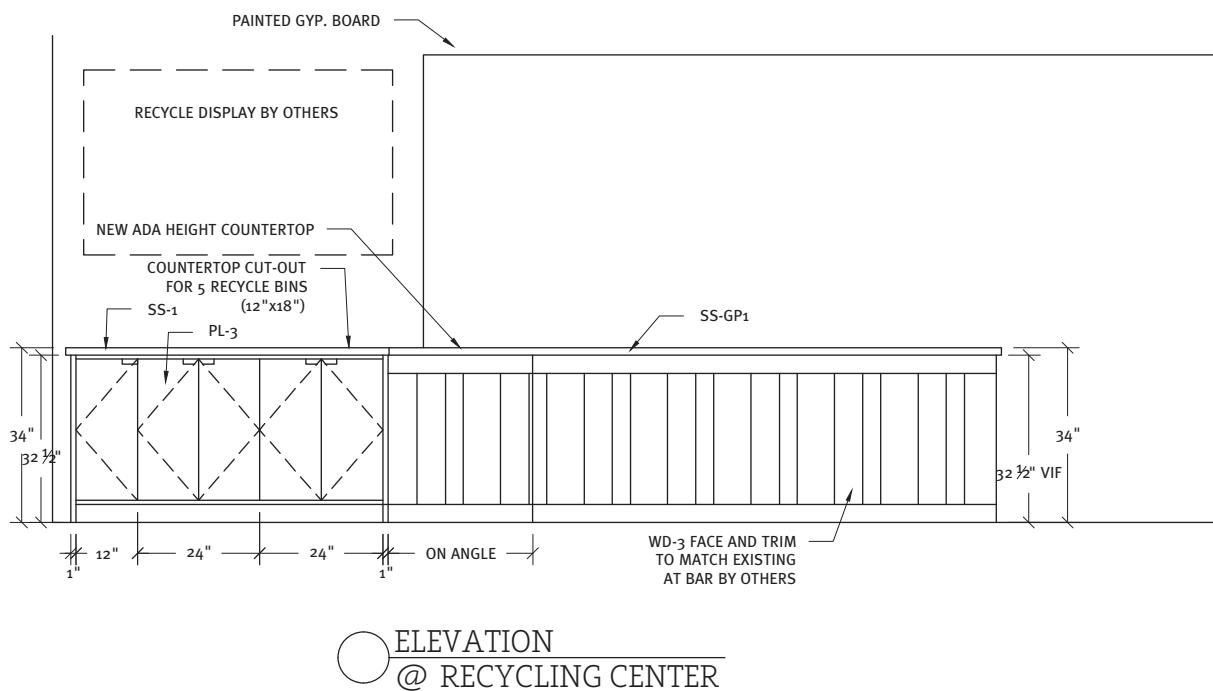
"Perhaps the most intricate work was in collaboration with our partner Grand Traverse Construction to preserve and refurbish the existing bar that was salvaged from the former golf course on the property," notes Collins. "We were able to preserve the original woodwork while cladding the top in place with grained solid surface with waterfall edges for a truly remarkable finished product."

Birch was the major wood used, adds Kendra, because of price and reference to regional materials for trim, doors and special casework. "All laminates and veneers are in natural tones. The mix of materials illustrate the range of local forests, and natural light and views reinforce the connection to the environment surrounding the project."

The bookcase wall in the executive conference room is "a stunning piece as is the presentation cabinet that hides the television and other equipment when not in use," he continues.

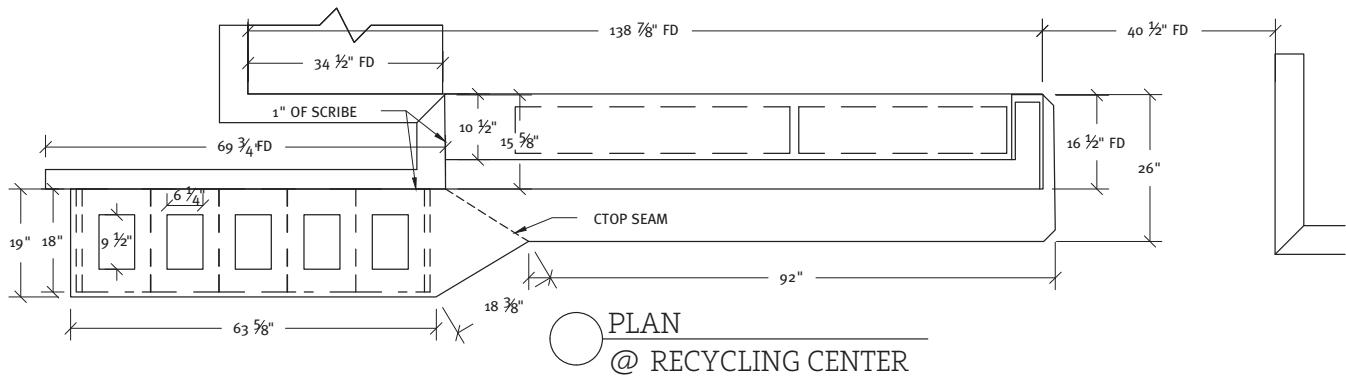
Meeting Challenges

"We partnered with a local architect and contractor with whom we have an excellent relationship," says Collins. "We worked closely to develop millwork/casework designs that paired beautifully with the other elements of the project. Everything was custom built to integrate into an extensive remodel with unique components from live edge slabs to massive sliding doors and collaboration spaces."



"Being a non-profit organization, GTRLC had a fixed budget with little to no room for changes. We paired affordably priced laminates with Dolkien edge banding to create stylish doors and panels. Strata was able to value engineer custom millwork to simplify construction methods while still providing a unique appearance with grained solid surface tops."

Ray Kendra as well as Grand Traverse Construction are longtime partners with Strata Design, points out Collins. "We appreciate their efforts in bringing millworkers into the design process early looking for ways to keep projects affordable but unique. It's refreshing to have an architect ask our opinion rather than only communicate via documents!" 



PROJECT:
**Grand Traverse
Regional Land
Conservancy HQ**
Traverse City, MI

PROJECT OWNER:
**Grand Traverse Regional
Land Conservancy**
Traverse City, MI

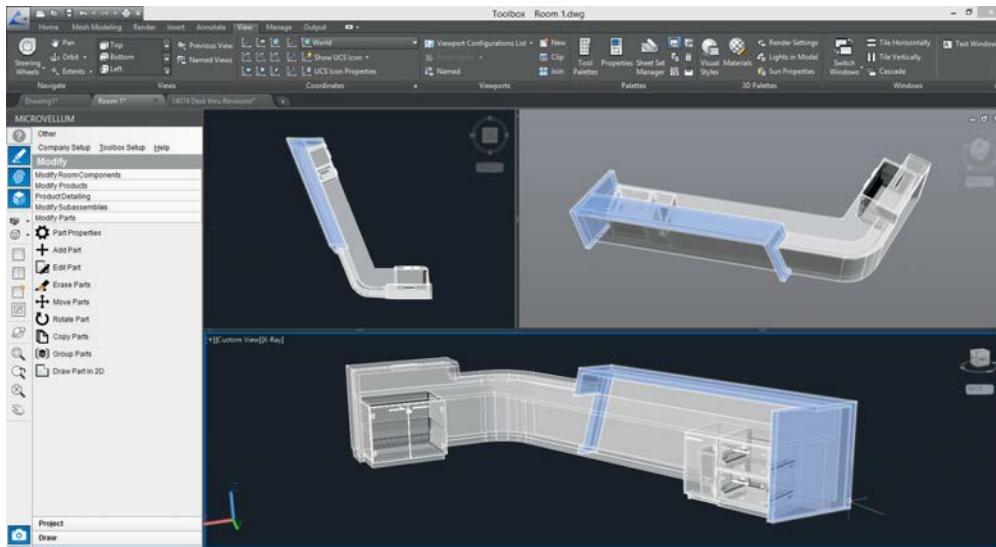
WOODWORKER:
Strata Design
Traverse City, MI

ARCHITECT:
**Environment
Architects**
Traverse City, MI

GENERAL CONTRACTOR:
**Grand Traverse
Construction**
Traverse City, MI

PHOTOGRAPHER:
**John Robert
Williams**
Traverse City, MI

Product Showcase

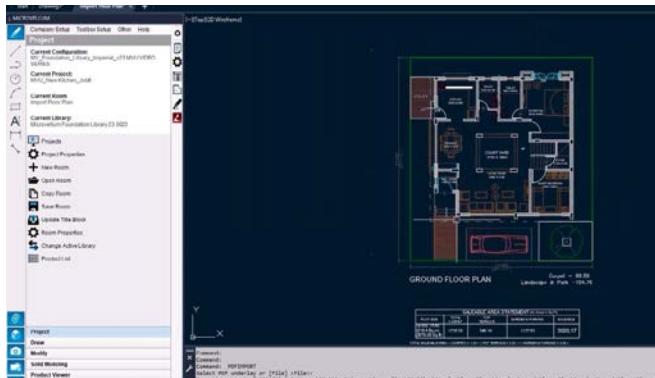


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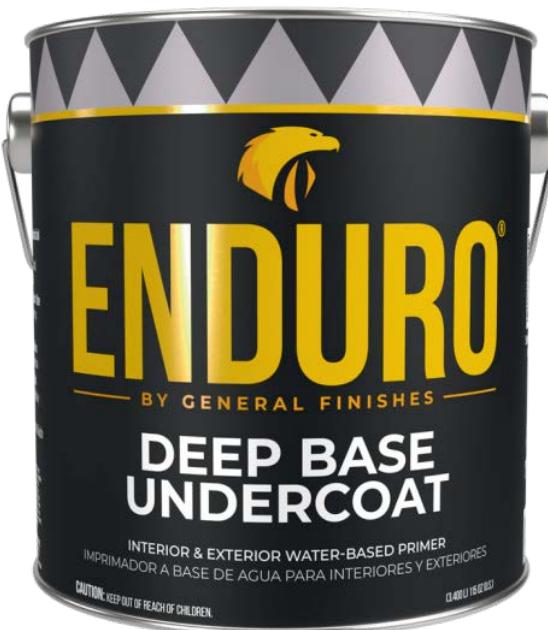
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Sustainable Housing.

Woodworking Firm Begins Building
Unique Green, Affordable Homes.





Large Urban Sustainable Homes, Milwaukee, Wisconsin, also known as “LUSH”, is a company that is rethinking how to build homes. The company has developed a new innovative construction technique that allows building homes entirely out of 3/4-inch plywood that’s snapped together using a rubber mallet. This new approach on how to process a home allows homes to be built faster, quicker, greener, and more energy efficient than a traditional home.



According to LUSH's founder R.J. Lange, the company is challenging the status quo and providing higher quality products in its homes, including 6x12 framing, 18-foot-high vaulted peak ceilings, hardwood engineered floors, custom architectural woodwork cabinets, and European style wardrobes. "Our first

fully constructed home built in Milwaukee is the largest structure using this technique in the world and we are in the process of building an even bigger structure," he explains. "We are looking to build attainable housing to help solve the housing crisis. Specifically, around entry-level homes but we have the capacity to also build higher end custom homes as well."

at a glance

AWI MANUFACTURING MEMBER:

Lange Bros. Woodwork Co.

LOCATION:

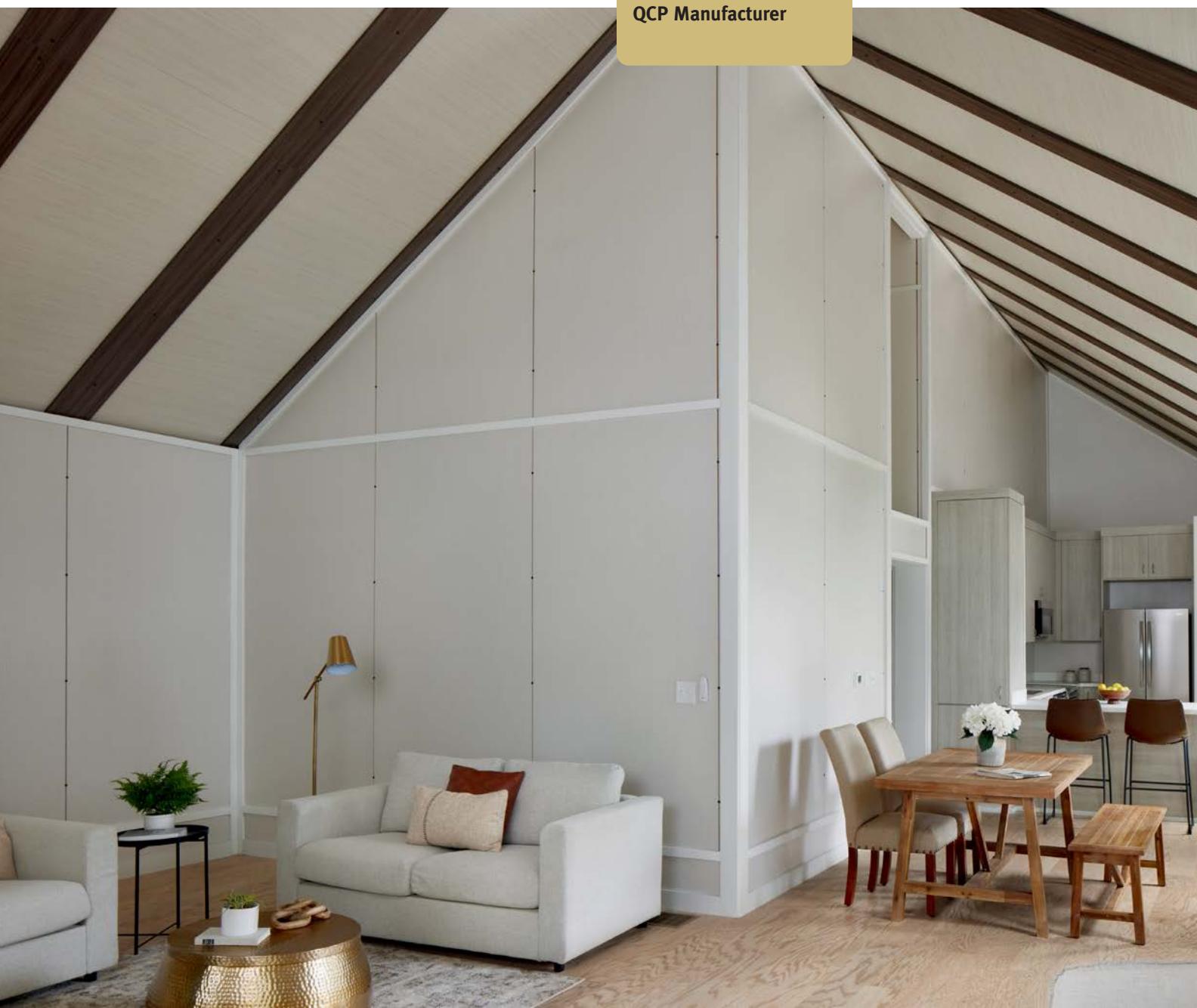
Milwaukee, Wisconsin

ESTABLISHED:

1930

Licensed QCP Manufacturer

The goal, he continues, was to achieve what is categorized in a lot of cities across the United States as "affordable" housing and wanted to provide a higher quality product that was achievable through better processing. "Coming from a woodwork manufacturing business, Lange Bros. Woodwork Co., Inc. we wanted to incorporate it into our business model."



Company Objectives

Some of the primary considerations are that wood helps LUSH build on our brands, says Lange, and gives a green aspect to construction and a more welcoming quality feel in a home that you don't see in typical entry level housing.



"LUSH took processing techniques learned through cabinetry building at Lange Bros. Woodwork Co., Inc. and applied it to home building. This can be seen in our homes that essentially snap together using 3/4-inch plywood to build the structure and thermal fuse panels to finish interior walls. Once you have the structure up using wood, we then applied the additional woodwork as well as European style wardrobes to replace closets to save space."

Daniel Pedro, LUSH's architect, notes that the typical home is 3,340 square feet and costs \$400,000. It uses plywood cut on CNC machines which are easy to assemble and fit different families.



The Woodwork

Structure, paneling, walls, windowsills, trim, cabinets, countertops, chairs, essentially all wood products for the project were fabricated and installed by Lange Bros. Woodwork Co., Inc., notes Randy Lange. "For the project, we used CDX plywood for the structure. All other materials were sourced from industry excess, including hardware, thermo-fused wall panels, solid surface, plastic laminates, and wood trim," he says.

"Our model doesn't necessarily allow for the buyer to pick the exact type of wood or color," explains R.J. Lange. "The reason for this is LUSH looks to take premium wood products that are used at high end traditional construction sites and reuse the leftover material at discounted prices. One could simply purchase the same material at a much higher cost, however, to become more efficient we use the excess material. So, if a customer is looking for white for their thermal fuse panels, we might not have the exact shade of white they want but can get one almost the same."

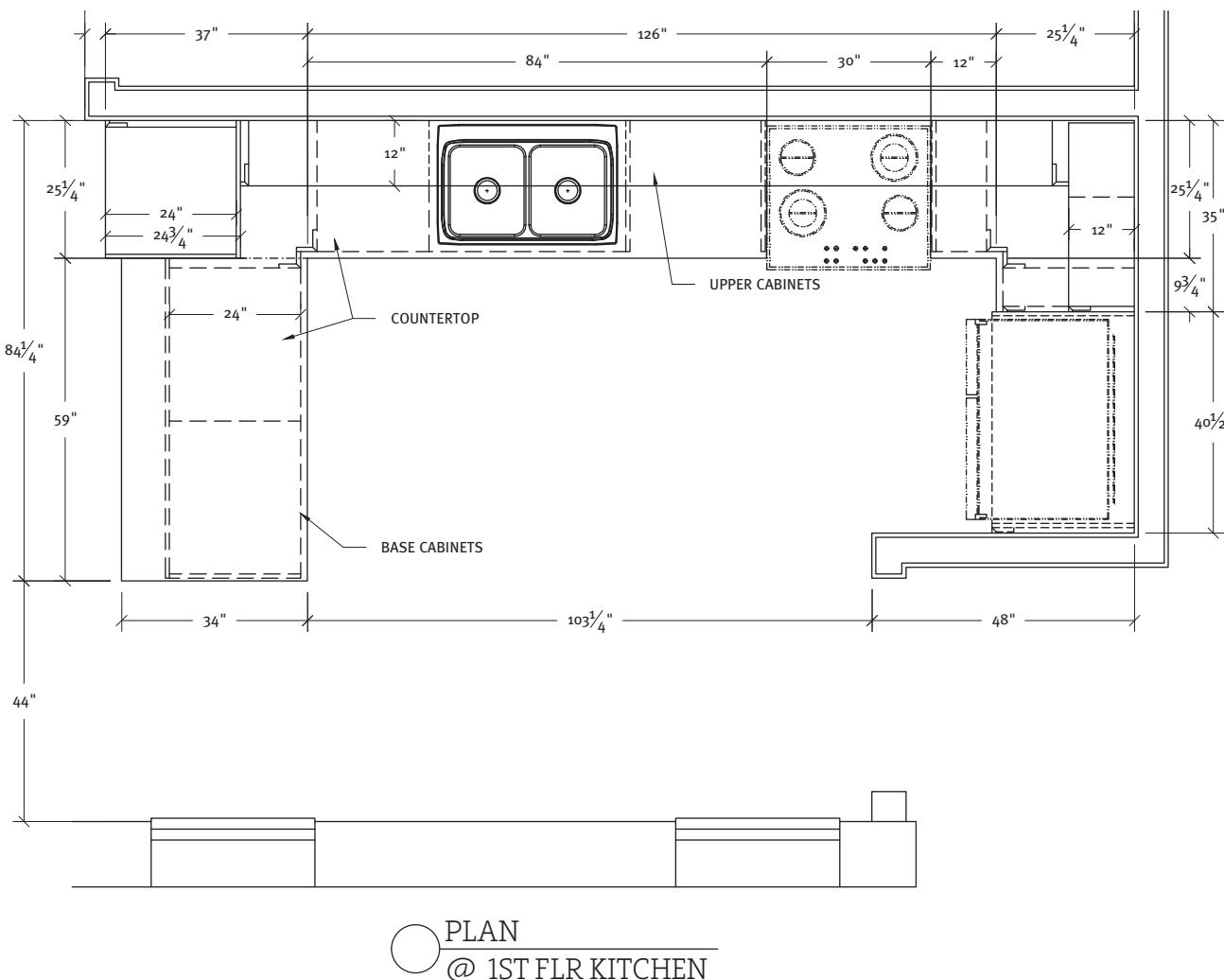


The most intricate and noteworthy woodwork item in this project is that it is the first and largest structure of its kind globally, Randy Lange continues. “It snaps together seamlessly with a rubber mallet and is constructed entirely from repurposed scraps, aligning with a zero-waste manufacturing process. Remarkably, the construction site required no garbage removal due to the minimal waste produced.

This innovative structure is designed to be net-zero-ready, promoting sustainability while offering enhanced safety, speed, affordability, and strength compared to traditional 2x4 construction. Impressively, the entire house can be assembled in just four days without the need for nails—all components are skillfully crafted to interlock using wood assembly techniques.”

“We are your partner, and from concept to completion, Lange Bros. collaborates with architects and contractors to ensure each detail is captured, translated into the design, the wood, and the finish, and finally the installation to create an inspirational interior.”

**— Randy Lange, Co-Owner,
Lange Bros. Woodwork Company**





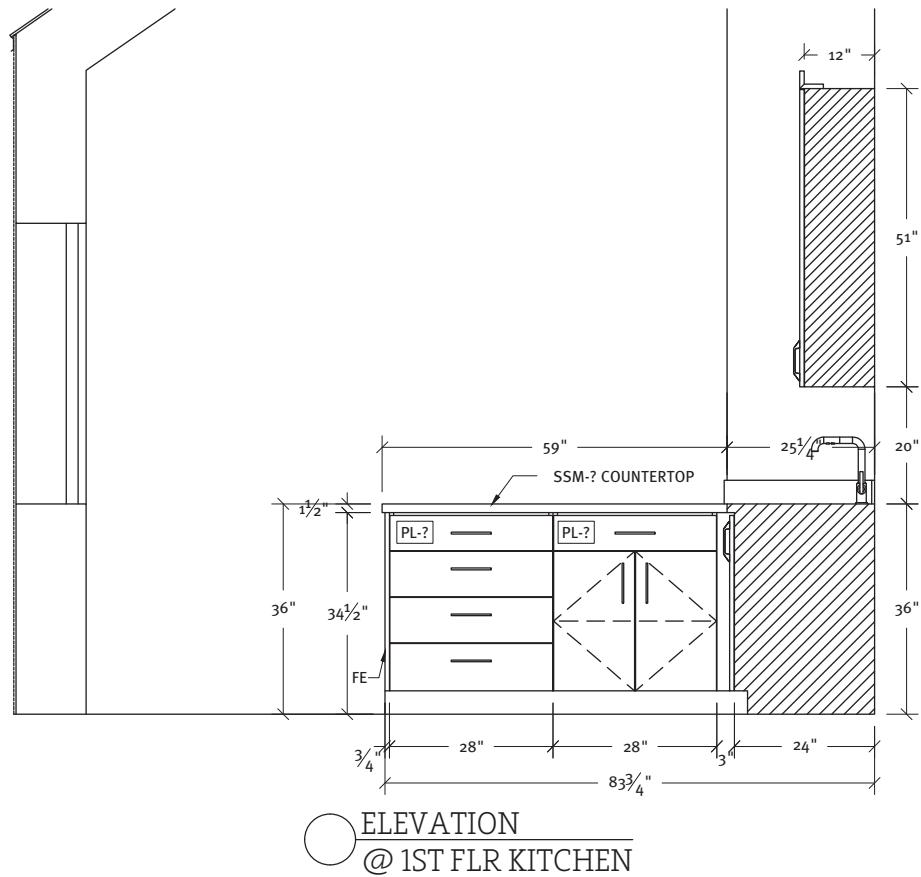
Adds R.J. Lange, "Over the years I have seen Lange Bros. Woodwork Co., Inc. produce a lot of high-quality items that have gone to numerous jobs, however for LUSH the most difficult and noteworthy to me are the beams and thermal fuse panels. This is simply because of the exciting innovation and the precision that is required to make sure the pieces snapped together are not too tight or too loose."



Pedro points out that obtaining the necessary building permits on a new type of structure was a challenge since it was never done before and difficult for the inspectors to understand the system.

Collaboration

Lange Bros. Woodwork Co. provided extensive support in project design, prototyping, and training various trades to enhance efficiency in project phases, says Randy Lange. “Additionally, we assisted with engineering and energy reports, conducted testing, and facilitated structured reviews to ensure project success. We analyzed home-building processes and encouraged the team to find ways to work faster and more efficiently. By fostering this approach, we achieved a 20-30% increase in productivity compared to when individuals were working based solely on personal preferences.”



He continues, “our architect played a valuable role in the design process, achieving a balanced design that harmonized form and function effectively.” 

PROJECT:
39th St. LUSH Home
Milwaukee, WI

PROJECT OWNER:
LUSH Homes
Milwaukee, WI

WOODWORKER:
**Lange Bros.
Woodwork Co., Inc.**
Milwaukee, WI

ARCHITECT:
**Lange Bros.
Woodwork Co., Inc.**
Milwaukee, WI

PHOTOGRAPHERS:
Libby Sutton
West Allis, WI

Andrea Clunie Perella
Milwaukee, WI

Architectural Veneer Panels: A Comparative Analysis

In the realm of architectural woodwork, the choice between stock architectural veneer panels and custom laid-up veneer panels is pivotal. This decision not only influences the aesthetic appeal of interior design but also has significant implications for the quality, cost, and schedule of the millwork scope in a construction project.



Stock Veneer Panels are pre-manufactured products available in standard sizes and leaf layouts, offering a cost-effective and time-efficient solution for many projects. Their mass production and standardization result in lower costs and shorter lead times, making them a practical choice for projects with budget limitations or tight schedules. However, the trade-off lies in the lack of options for customization, and potential for less stringent quality control due to the nature of mass production.

On the other hand, **Custom Laid-up Veneer Panels** are tailored specifically for your project, providing design professionals with greater control over the final appearance and quality. The meticulous selection and arrangement of individual veneer leaves allow for unique patterns, slip-matching, and other desired effects, enhancing the project's unique character and overall aesthetic value.

A premium is expected for the chosen customizations and in cost and lead times due to the additional labor and expertise required in custom panel creation. Nevertheless, the rigorous quality control processes and the flexibility to match specific design requirements justify the investment for projects where quality and design integrity are paramount.

IMPACT ON QUALITY, COST, AND SCHEDULE.

Quality: custom panels undergo more rigorous quality control processes, ensuring each panel is individually crafted and inspected according to the specifications for leaf cut, color, grain, figure, orientation, leaf matching, panel matching and sometimes core material. This attention to detail results in a higher quality product that can meet the aspirations of high-design projects. Stock panels, while still adhering to quality standards, will likely not meet with the bespoke nature of the custom designed and fabricated panels that will enhance the project at hand.

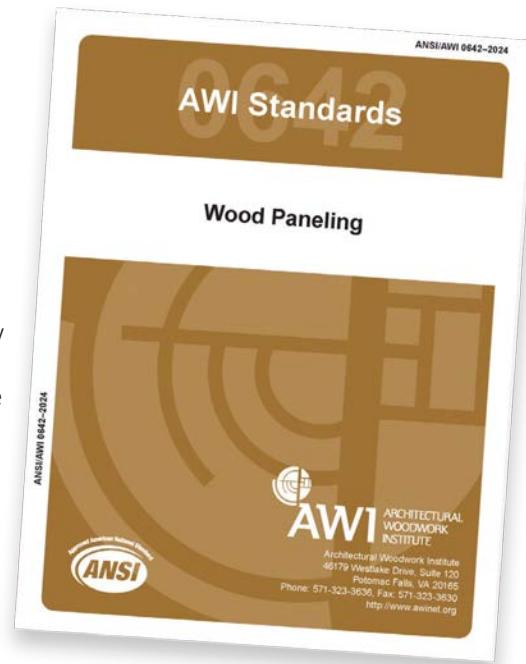
Cost: the cost-effectiveness of stock veneer panels makes them an attractive option for budget-conscious projects. In contrast, custom panels require a larger financial outlay, reflecting the labor-intensive process of their creation. Design professionals must anticipate this in the budgeting process perhaps by some pre-bid exercises in which the specifications and paired with a few species, cuts and figures to determine the options that balance the project's financial constraints with the desired level of customization and quality.

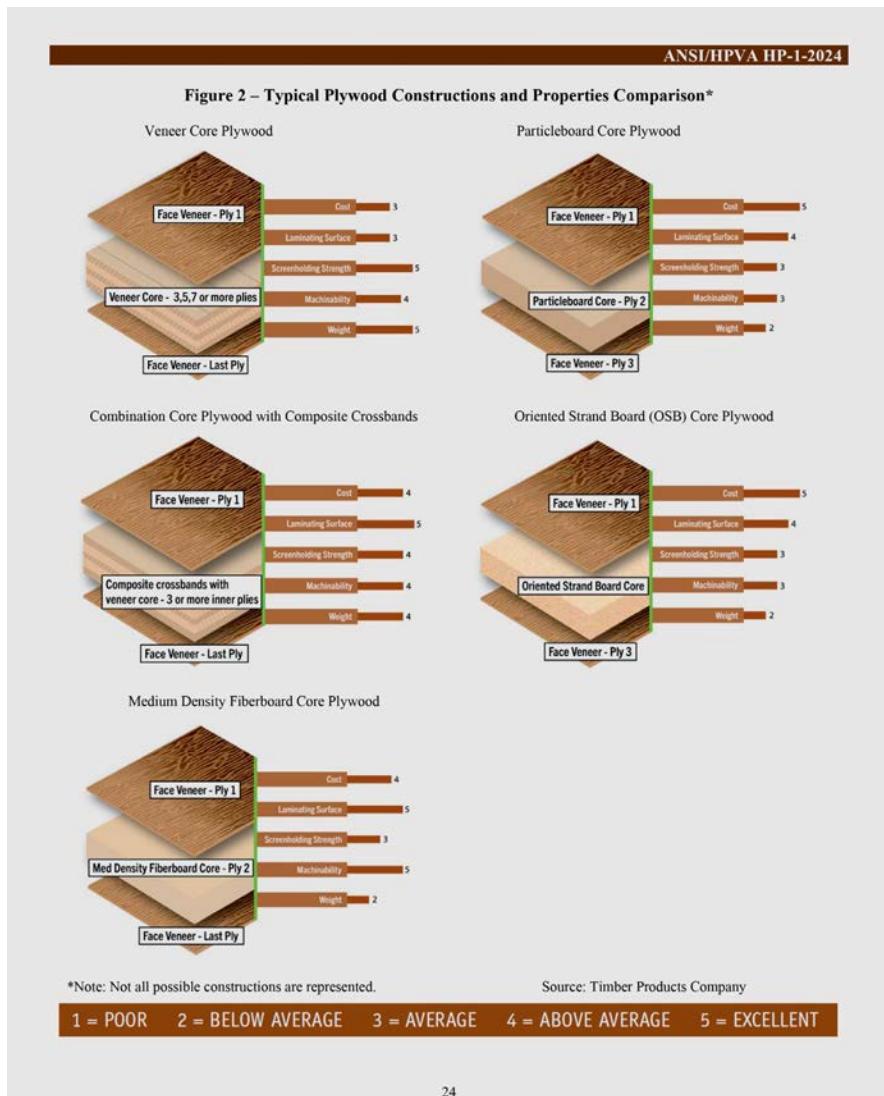
Schedule: stock panels' availability may help ensure shorter lead times if the desired quantity of panels happen to be available that meet the aesthetics of the project, which is crucial for projects on a strict timeline. Custom panels, with their longer fabrication and quality control processes, necessitate advanced planning to accommodate the extended lead times. Depending on the room layout and the specified room or wall matching method, especially if the veneer is expected to cover doors or other components in the space may need to be planned a few weeks in advance of typical panel acquisition scheduling.

While stock panels have countless practical applications as a supporting material component in many woodwork projects, there comes a time when the bridge is crossed in the design phase when it becomes apparent that the limitations of stock panels will not provide the necessary aesthetic elements or special structure necessary to carry the project to the desired outcome. When that bridge is crossed, the best tool available to help navigate the world on the other side of the bridge is the new *ANSI/AWI 0642-2024 Wood Paneling Standard*.

This new standard is a reliable guide to understanding how to successfully plan and evaluate custom paneling that will appear on walls and ceilings in a custom woodwork project. Included are specifics about including solid lumber stile and rails, wood veneer, decorative laminate clad panels, application to core materials, solid surface materials and solid phenolic materials. Like all AWI's new standards, this standard establishes the minimum aesthetic and performance expectations and measures.

Installation is covered in *ANSI/AWI 0620-2024 Finish Carpentry/Installation OR ANSI/AWI 0620-2018 Carpinteria de Acabado/Instalacion*. As the new standards are used internationally, it is appreciated that the dimensions and tolerances are stated in metric, then standard imperial (SI), then decimals where needed during machining. To aid in the use of AWI Standards globally, AWI's membership now spans 14 countries so you can be confident that specifying AWI standards will result in adherence to the standards.





THE DESIGN PROFESSIONAL'S ROLE IN VENEER SELECTION.

Architects, interior designers and construction specifiers can add significant value to the project for their clients by guiding the veneer selection process. By choosing a veneer flitch—a bundle of veneer leaves cut from a single log—in advance, the quality can be assured, costs brought under control and consequently, maintain the integrity of the design vision for the project's owner. This proactive approach not only streamlines the bidding process but also enhances client satisfaction by involving them during material selection, leading to a final product that aligns with their expectations. No surprises!

It's easy to visualize the level of quality you can expect in the components when you refer to the charts that describe and detail the tolerances of material components illustrated in the aesthetic quality charts that start on page 5. Longtime users of *AWI Standards* will immediately feel at home when they find the critical information they seek in the graphs headed by the familiar AWI Aesthetic grades: **Premium, Custom and economy**, with Premium Grade defining the highest degree of control over materials, workmanship and manufacture.

These tell the reader how it needs to look and the measurable tolerances within each grade. This makes it easy to plan out the level of quality that is expected for each part of the project and provides measurables to evaluate if the delivered products meet the criteria in the standard that was specified. If something is called into question, the exact location in the standard that backs up your concern can be found. Finally, once the decision is made about the wood species characteristics and grade are made, you can proceed to the remaining critical specification elements to complete the picture.

WORKING WELL TOGETHER.

Making hardwood veneer selection for custom panels starts with the selection of the wood species itself. Every piece of wood has its own properties and characteristics which allows for a wide range of grain, figure and color to appear on the face of any wood specie veneer leaf. How does one specify what it should look like? Thankfully, the robust woodwork industry has a number of organizations that produce and keep current, the standards specific to their arm of the industry.

For decades, the **Decorative Hardwoods Association** (previously known as HPVA -Hardwood Plywood and Veneer Association) has maintained the standard that defines the visible characteristics that can appear on hardwood veneer and divides them into grades that help the specifier and design professional know what to allow and what to expect on the surface of the veneered panels and doors. The *ANSI/HPVA-HP-1 2000* standard pages 14 – 24 provide charts that compare wood species characteristics within six grades.



Knowing how wide the leaf of veneer is expected to be in the specie you are selecting, how many knots of what size can be seen within a given proximity, what kinds of natural characteristics and marks are acceptable in a specie as well as what manufacturing characteristics are, and which are allowed, is all helpful in the planning process and again to evaluate the delivered products. Each chart covers dozens of considerations all placed on a graph that helps you write an exact specification that provides clarity to those bidding the project and those who review those bids.

Once the species and grade is chosen, it's time to get some samples of actual veneer leaves that fit that description to see if the specification fits your reality. Contact one of AWI's veneer suppliers to get samples sent to you for your design team and woodworker to inspect.

[https://www.
decorativehardwoods.org/sites/
default/files/2024-10/ANSI-HPVA%20
HP-1-2024.pdf](https://www.decorativehardwoods.org/sites/default/files/2024-10/ANSI-HPVA%20HP-1-2024.pdf)

The design professionals on the project can now make the final decisions about the veneer layout by getting the rest of the information from a new education resource book that AWI will be publishing soon. You'll choose :

- *The method of slicing the veneer to reveal the desired grain pattern: Plain, Quartered, Rift or Rotary;*
- *Matching between the leaves of veneer: Book match, Slip match, Swing match, Slip and Center match, Random match;*
- *Panel to Panel Match: Running match, Balance match, Balance and Center match; and*
- *Room layout: Sequence match or Blueprint match.*

CONCLUSION.

The choice between stock and custom laid-up veneer panels is more than a matter of preference; it is a strategic decision that affects the overall success of a construction project. While stock panels offer cost and time advantages, custom panels provide unmatched quality and design flexibility. Design professionals and construction project managers play a crucial role in navigating these options together with the AWI woodwork manufacturer, ensuring that the selected veneer aligns with the project's goals and the client's vision. By understanding the nuances of each available option in the design and budgeting process, and their impact on quality, cost, and schedule, informed decisions will be made that enhance the obvious value and satisfaction of architectural woodwork projects. 

Editor's Note: Content contributed by: AWI New England Chapter, the 2024 AWI Chapter of the Year, and Margaret Fisher who is celebrating 40 years in the wood industry.



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- * **Artisan Millworks, artisanmillworksllc.com**
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- Atlanta Cabinet Shop, atlantacabinet.com**
678-288-4917, gbalcom@atlantacabinet.com
- Augusta Sash & Door Sales of GA, Inc.**
augustasash.com
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cbdga.com
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- * **Century Caseworks, centurycaseworks.com**
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cfxproducts.com
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- * **Columbus Cabinet Co., columbuscabinet.com**
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- * **Commercial Bank & Business Equipment,**
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- * **Division 6 dba Royal Custom Cabinets,**
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- DMA Custom Millwork
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586-725-8227, mgaglio@modinteriors.com

* **National Specialty Contractors, LLC**,
nationalspecialtycontractors.com
734-985-2371, cpaine@nceusa.com

Perspectives Cabinetry
perspectivescabinetry.com
248-288-4100, dave@perspectivescabinetry.com

Phillip Elenbaas Millwork
elenbaasmillwork.com
616-791-1616, ben@elenbaasmillwork.com

Steelcase, Inc., steelcase.com
616-247-2710, dblock@steelcase.com

* **Strata Design**, stratadesign.com
231-929-2140, tcerny@stratamail.com

• The Worden Company
800-858-7746, twalker@wordencompany.com

* **Trend Millwork**, trendmillwork.com
313-383-6300, jmorche@trendmillwork.com

Minnesota

Andersen Cabinet, Inc., andersencabinet.com
651-777-5377, anderst@andersencabinet.com

Artifex Millwork, Inc., artifexmillwork.com
651-462-5137, bmiller@artifexmillwork.com

CTB, Inc., ctbcorp.com
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Distinctive Cabinet Design
distinctivecabinet.com
320-968-4351, alex1@distinctivecabinet.com

Focal Point Fixtures, Inc.
focalpointfixtures.com
320-203-1100, scott@focalpointfixtures.com

Genereux Fine Wood Products
763-295-4222, andrew@genereux.us

* **Goebel Fixture Company**, goebelfc.com
320-587-2112, mfield@goebelfc.com

* **Hansen & Company Woodworks**,
hcowoodworks.com
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* **ICG, icg365.com**
320-230-9525, ryans@icg365.com

Madsen Fixture & Millwork
madsenfixture.com
651-982-6220, kes@madsenfixture.com

Minnkor Industries, minncor.com
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* **Northwest Cabinets, Inc.**,
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Product Design Services, pdsfixtures.com
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R.C. Smith Company, rcsmith.com
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* **Shaw/Stewart Millwork**,
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* **Siewert Cabinet & Fixture Mfg. Inc.**,
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612-721-4456, rws@siewertcabinet.com

* **Southern Minnesota Woodcraft, Inc.**,
smwood.com
507-334-4985, bcohen@smwood.com

St. Germain's Cabinet, stgermaincabinets.com
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Viron Holding Co. dba Janish Wood Products,
janishwood.com
763-434-9090, peter.adams@janishwood.com

* **Wilkie Sanderson**, wilkiesanderson.com
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Mississippi

Associated Architectural Products, Inc.
associatedinc.com
662-245-0400, jferguson@associatedinc.com

* **Commercial Millwork Specialist, Inc.**,
comillspec.com
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* **McNeil Cabinet & Millwork**,
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* **Scanlon-Taylor Millwork Co.**
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sawms.com
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Wood Works LLC, woodworksms.com
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acgiwood.com
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* **C.S. Humphrey & Company**, cshumphrey.com
816-444-8100, shumphrey@cshumphrey.com

* **Cabinet Masters, Inc.**, cmibuild.com
573-546-9999, mdunn@cmibuild.com

* **CKC Woodworks**, ckcwoodworks.com
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* **Cohen Woodworking**, cohenwoodworking.com
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* **Fixture Contracting Co.**, fixturecontracting.com
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* **Gravois Planing Mill, Inc.**
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sandydodson@gravoisplaningmill.com

• JE Dunn Construction
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Lancia Brothers Woodworking & Fixture Manufacturing Co.
314-721-0413, bob@laciabrothers.com

• McCown Gordon Construction
816-960-1111, awingert@mccowngordon.com

Merric Millwork and Seating, merric.com
314-770-9944, dan@merric.com

Northwest Cabinet Works,
nwcbinetworks.com
406-752-8383, john@nwcbinetworks.com

* **S&W Cabinets, Inc.**, swcabinets.com
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sevillewoodworks.com
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• Tops Unlimited, Inc., tops-unlimited.com
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314-781-1178, reneee@waterhout.com

* **WoodByrne Cabinetry, Inc.**, woodbyrne.com
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308-324-5825, travis@designercraft.net
- * **Kay Dee Company of Omaha**, kaydeeco.com
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- Ramco Enterprises**, ramcoenterprises.com
402-742-6588, ramsey@ramcoent.com
- * **Ratigan-Schottler**, ratiganschottler.com
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775-322-0000, alberto@bandccabinets.com
- CMD INC., cmdnv.com
702-990-4478, adriana@cmdnv.com
- * **Complete Millwork Services**, cmsrno.com
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- * **Herrick & O'Herron**, herrickandoherron.com
702-651-9725, brian@herrickandoherron.com
- * **Pacific Showcase**, pacificshowcase.net
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- * **Victory Woodworks**, victorywoodworks.com
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- White Space**, int-sourcing.com
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- * **New England Finish Systems (Custom Installations Division)**, fineinstall.com
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- * **Procraft Corporation**, procraftcorp.com
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- * **The Woodworks Architectural Millwork Co.**, twnh.com
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- * **Osborn's Mill**
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- * **Prestige Millwork**, prestigemillworkllc.com
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201-488-7888, walter@saloninteriors.com
- * **Sloan & Company**, sloanandcompany.com
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- Somerset Wood Products Co.**
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- Sound Fabrication**, sound-fab.com
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- Victor Robbins Group LLC**, vrgwood.com
609-267-0080, rschultz@vrgwood.com

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- BON Architectural Millwork**, bonwoodinc.com
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- Collingswood Architectural Millwork, Inc.**, collarch.com
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- * **Corporate Woodworking, Inc.**, corporatewoodworking.com
973-227-2211, mark@andersencompanies.com
- DH Interiors LLC**, dhinteriors.us
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- Diversified Fixture**, diversifiedfixture.com
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- Eastern Millwork, Inc.**, eastern-millwork.com
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- * **Epic Millwork**, epicbuilds.com
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- * **Fabuwood Cabinetry Corp.**, fabuwood.com
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- Hutchinson Cabinets**, hutchinsoncabinets.com
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leonardof@materialsinconline.com
- * **May Cabinets Inc.**, maycabinets.com
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- Narva Springfield**, narvawoodwork.com
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- * **Antix, Inc.**, antix-inc.com
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- * **Artistic Millwork & Cabinets**
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- * **Enterprise Builders Corporation**, ebnm.com
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- * **Fame Mfg/NM School Products**, newmexicoschoolproducts.com
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- * **Jaynes Structures, Inc.**, jaynescorp.com
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- * **OGB Architectural Millwork**, ogb-am.com
505-998-0000, mwann@ogb-am.com
- * **P&M Caseworks, LLC**, pmcaseworks.com
505-883-4617, adrian@pmcaseworks.com
- Westwood Cabinets and Store Fixtures**, westwoodcabinetsandstorefixtures.com
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- All Craft Fabricators, Inc.**
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- ArchWood, Inc., archwoodworks.com**
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- * Artone Manufacturing Company, Inc., artonemfg.com**
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- * Bauerschmidt & Sons, Inc., bauerschmidt.us**
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607-545-6382, gb2@beavercreekindustries.com
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- Carpentry and Millwork
914-840-9187, cmillwork150@gmail.com
- Centre Interiors Woodworking Co., Inc.**
718-323-1343, alexl@centrenyc.com
- * Certified Interiors, Inc., certifiedinteriors.com**
631-225-1300, robert@certifiedinteriors.com
- Champion Millwork, Inc.**
315-463-0711, mark@championmillwork.com
- * Christiana Millwork, christianamillwork.com**
315-492-9099, karl@christianamillwork.com
- * Clearwood Custom Carpentry & Millwork LLC dba One Source Millwork, onesourcemillwork.com**
315-863-7770, klatray@onesourcemillwork.com
- CNZ Contracting**
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- Creative Laminates, Inc.**
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- Dart Millwork LLC**
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- * Forest Materials Inc, forestmaterials.com**
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- Furniture Design Knossos Inc.**
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- Gilbert Displays, Inc., gilbertdisplays.com**
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- Platinum Millworks,, Inc.**
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- Quaker Millwork and Lumber, quakermills.com**
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- Red Barn Cabinet Shop, redbarncabinet.com**
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- Ridge Cabinet & Showcase, ridgecabinets.com**
585-663-0560, steve@ridgecabinets.com
- * Riverfront Custom Design, Inc., rfront.com**
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718-361-9888, johnny@donadic.com
- * Scanga Woodworking Corp., scanga.com**
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- Caseworx, caseworxncc.com**
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- * D & L Cabinets, Inc., dandlcabinetsinc.com**
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920-842-2136, bkelly@diversifiedcasework.com
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- * Hardwood Designs, hardwooddesigns.com**
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704-788-2319, steve@ikesmillwork.com
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* **Rowland Woodworking, Inc.,**
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 - * **Pioneer Millworks, Inc., pmillworks.com**
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 - * **Quest Millwork, questmillwork.com**
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 - * **R & R Millwork, randrmillwork.com**
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 - RD & S School Equipment Co., LLC**
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 - RiverCity Cabinets, rivercitycabinets.com**
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 - * **Roomi Group Corporation, roomigroup.com**
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 - * **Signature Cabinets, p-lam.com**
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 - Signature Millwork, signaturemillwork.com**
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 - * **Boswell Wasatch Mill, boswellwasatch.com**
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 - * **Contempo Cabinet & Mill, contempocabinet.com**
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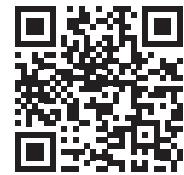
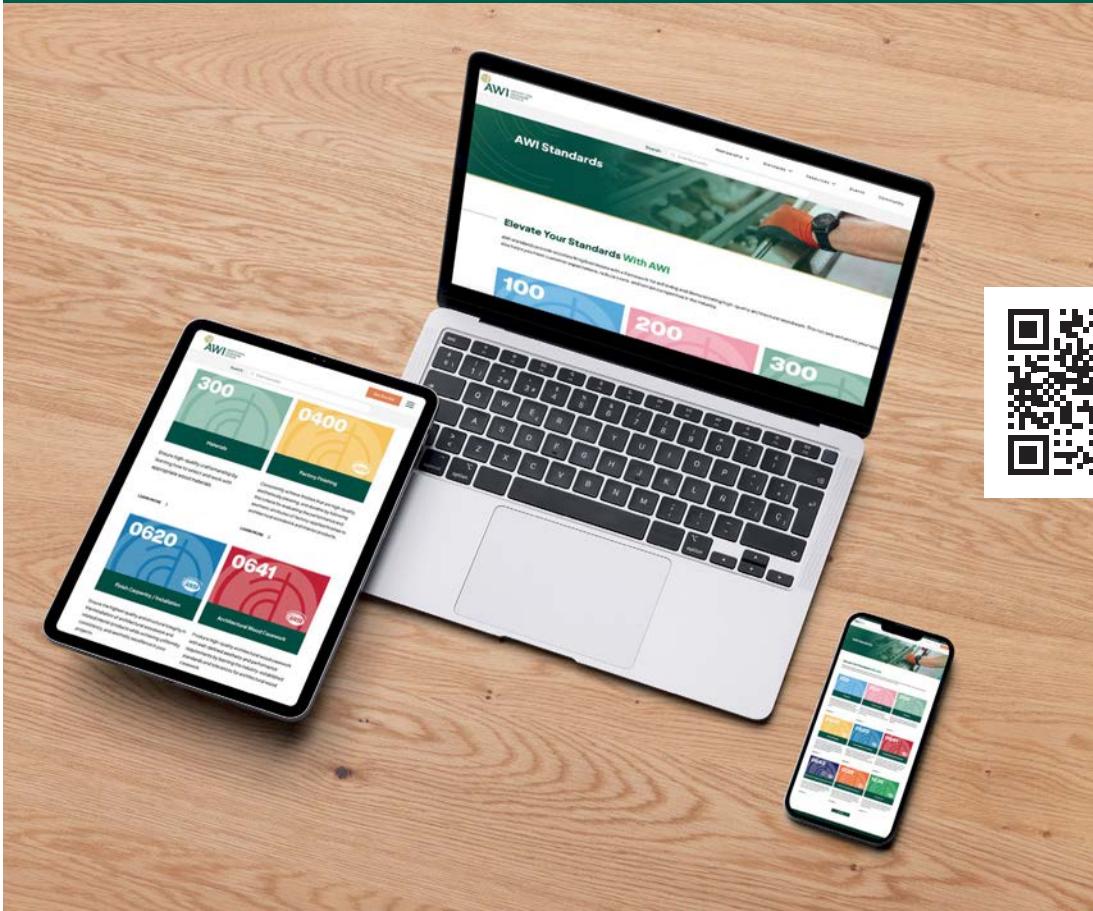
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