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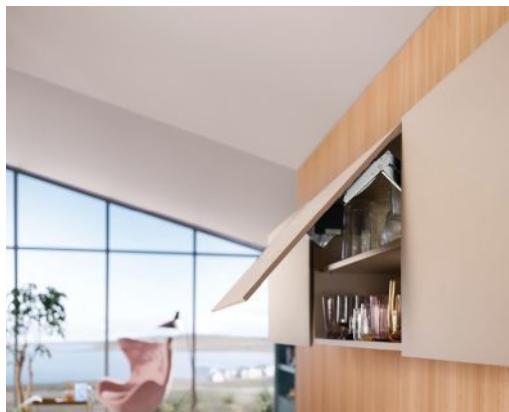
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Jennifer Hicks (top, cover)



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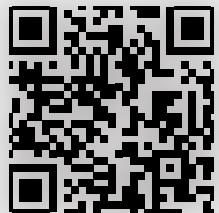
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BLOGS



Over the Workbench

Talkin' shop with former editor A.J. Hamler

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AWFS seeks entries for Fair competitions

By Tod Riggio

The Association of Woodworking & Furnishing Suppliers (AWFS) is accepting entries for the 2025 Fresh Wood student woodworking competition. Finalists will be invited to exhibit their projects at the upcoming AWFS Fair, July 22-25, in Las Vegas.

"High school juniors and seniors, as well as post-secondary students in woodworking and related programs across the United States, are encouraged to submit their projects for this prestigious opportunity," the AWFS said in a statement. "The competition provides a unique platform for student woodworkers to showcase their craftsmanship to thousands of industry professionals and gain national recognition."

Entry categories include tables, chairs, design for production, case goods, open, and the special theme: Spin N' Shape. Top winners receive monetary prizes, trophies, and industry exposure. The entry deadline is May 2. Learn more at awfsfair.org/fresh-wood.

The AWFS is also seeking entries from its 2025 exhibitors for the Visionary New Products Awards and Showcase. The entry categories are A.I./Machine Learning/Robotics (new for 2025); Machinery Over \$50,000; Machinery Under \$50,000; Power Tools; Hardware; Components; Tooling, and Software. There's also a general category. New exhibitors can enter a product in the New Exhibitor Showcase. All entries must be received by June 2 and submitted through the Visionary New Product website at

visionaryaward25.artcall.org.

There have been a couple major acquisitions in the woodworking software realm, including KCD Software's addition of CADCode Systems. For details, please see our story on page 8.

Innergy, a provider of ERP software for custom millwork and cabinetry manufacturers, has announced the acquisition of Microvellum, a provider of design for manufacturing software.

"This is an incredible moment of growth for our industry," said Marc Sanderson, CEO of Innergy, in a statement. "For years, I've listened to woodworking business owners share their challenges around engineering bottlenecks and the growing complexity of modern millwork businesses. By bringing together Innergy and Microvellum, we're tapping into decades of industry expertise to solve these challenges and create new opportunities for our respective customers."

"This is an exciting moment for the millwork industry," added David Fairbanks, President of Microvellum. "We are thrilled to join forces with Innergy to pursue our vision of a world where people have the freedom and flexibility to create extraordinary things with ease. By bringing Innergy and Microvellum together, we believe we will achieve that vision."

Both organizations will continue to operate separately while collaborating on new features that benefit their customers. The existing leadership teams will remain in place, the companies said. **W**

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EDITOR TOD RIGGIO
ART DIRECTOR CHRIS CIRILLI
STAFF WRITER JENNIFER HICKS
CONTRIBUTING WRITERS
JOHN ENGLISH, DAVID GETTS AND TED BRUNING

SALES & MARKETING

PUBLISHER
RORY BEGLIN
203-952-6790; rory@woodshopnews.com

CLASSIFIED MARKETPLACE ADVERTISING
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SENIOR VICE PRESIDENT, CONTENT **ROB YAGID**
GROUP ADVERTISING DIRECTOR, WOODWORKING
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HEADQUARTERS:

Active Interest Media 2143 Grand Ave. Des Moines, IA 50312

Editorial E-mail: editorial@woodshopnews.com

Advertising E-mail: sales@woodshopnews.com

Website: www.woodshopnews.com

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KCD Software acquires CADCode Systems

By Jennifer Hicks

KCD Software, a provider of software solutions for custom cabinet and closet professionals, announced the acquisition of CADCode Systems, a developer of CNC machining software, in March.

"We are thrilled to welcome CADCode Systems into the KCD Software family," Cadman Campbell, president of KCD Software, said in a statement. "This acquisition is a natural fit for our mission to empower everyone from designers to manufacturers with powerful, intuitive software solutions. CADCode has been a true pioneer in production automation and CNC integration, shaping the industry with its innovative technologies. Their expertise perfectly complements our existing product offerings, allowing us to provide a seamless workflow from design to production."

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Big turnout at IBS

By Jennifer Hicks

More than 81,000 builders, remodelers, developers and other industry professionals attended the International Builders' Show (IBS), held Feb. 25-27 at the Las Vegas Convention Center, marking the show's largest turnout in 17 years.

Hosted by the National Association of Home Builders (NAHB), the IBS is the largest annual light construction show in the world.

"This year's show surpassed our high expectations for attendance, exhibit space and educational opportunities," NAHB chief revenue officer Geoff Cassidy said in a statement. "Attendees saw the latest trends in home technology and resilience, and the latest advancements in build-



Founded in 1982, KCD Software provides design-to-manufacture software tailored to custom cabinet and closet professionals. By integrating CADCode Systems' advanced CNC and optimization technologies, KCD Software said it will now offer expanded solutions with the capability to enhance automation, improve material yield, and increase production efficiency.

"CADCode Systems, based in Skillman, N.J., offers advanced software solutions that enable manufacturers to optimize workflows and reduce waste. With this acquisition, KCD Software plans to integrate CADCode's technologies into its CNC suite of solutions while continuing to support and enhance CADCode's existing offerings for its loyal customer base," the company said.

Learn more at kcdsoftware.com. **W**



Scenes from the 2025 International Builders' Show in Las Vegas.

ing techniques."

This year also marked the 12th anniversary of Design & Construction Week (DCW), the co-location of IBS and the National Kitchen & Bath Association's Kitchen & Bath Industry Show (KBIS). DCW drew over 124,000 attendees and nearly 2,500 exhibitors, according to the NAHB.

There were over 1,800 exhibitors at IBS, including 750 new exhibitors. The show also featured over 120 education sessions covering the latest building products and techniques, industry research and trends, and more. Two demonstration areas focused on best practices for building more durable, efficient, higher-quality homes. There were also numerous networking events.

Next year's IBS and DCW is scheduled for Feb. 17-19 in Orlando. Learn more at buildersshow.com. **W**



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Kelly Victor-Burke Joins WCA Board of Directors

By Jennifer Hicks

The Woodwork Career Alliance of North America (WCA) has elected Kelly Victor-Burke, co-owner of Burke Architectural Millwork (BAM), to its board of directors.

Victor-Burke, an entrepreneur and advocate for woodwork manufacturing, co-founded BAM in Livonia, Mich., along with her husband Barry in 2016. BAM is Michigan's first certified women's business enterprise in custom architectural millwork awardee from the Women's Business Enterprise National Council. In 2023, the couple expanded their portfolio with the launch of Bespoke Closets & Organized Spaces, a luxury organized spaces company.

Victor-Burke spearheaded the creation of the Woodwork Manufacturing Specialist apprenticeship, the first 21st-century Department of Labor registered apprenticeship in woodworking, addressing the industry's skills gap through comprehensive training in CAD/CAM, mechatronics, and other key areas. BAM was subsequently named a U.S. Department of Labor Office of Apprenticeship "Apprenticeship Ambassador" in 2022.

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WOODSHOPNEWS



nesses program, Victor-Burke has been recognized as a "Notable Women in Manufacturing" by Crain's Detroit Business and a "Market Leader" by the Woodworking Network. She also holds the title of professor emeritus from Eastern Michigan University, where she taught for 30 years.

"As a retired educator, the mission of the WCA holds a special place in my heart," Victor-Burke said. "I am deeply honored to serve on the board to support its efforts to bridge education and businesses to careers in the wood industry."

"Kelly's dedication to closing the skills gap through initiatives like her registered apprenticeship program aligns perfectly with the WCA's core values," said Scott Nelson, president of the WCA. "We are excited to have her advocacy and experience on our board."

Learn more at www.woodworkcareer.org. **W**



Kelly Victor-Burke

Asheville shop wins Colonial Saw giveaway

By Jennifer Hicks

Colonial Saw has awarded a Lamello Zeta P2 biscuit joiner system to Bryan Kerr, an owner of Kerr Woodworking in Asheville, N.C., in a contest celebrating the production of the 100,000th Zeta tool.

Like many throughout the Asheville region, Kerr's business suffered catastrophic damages from Hurricane Helene in September 2024. He is in the rebuilding stage and says winning the new tool will certainly help.

"I feel very grateful that we won. It came at a really good time. We had just lost our entire shop from flooding from Hurricane Helene here in Asheville. So, we were in the process of buying new tools and outfitting a new shop because we lost pretty much everything shop-related," Kerr says, adding that he entered the contest online not expecting to win.

"It was great timing. I've been doing woodworking now for over 20 years, and it's a tool that I've had available to me in larger shops that I've worked for. I personally didn't buy one



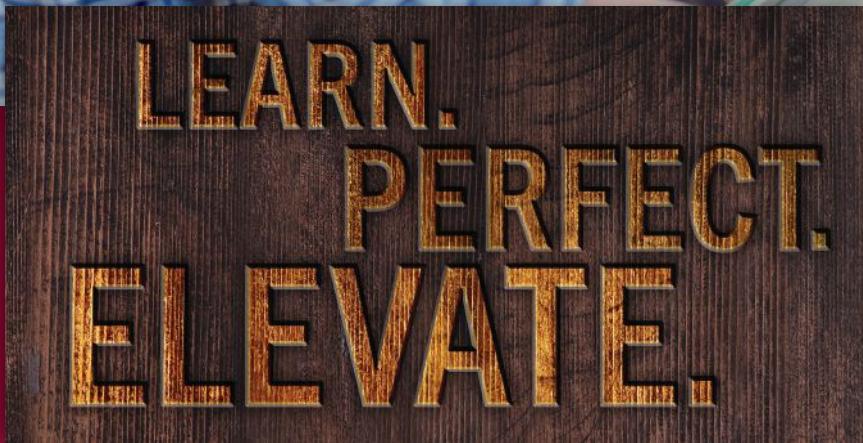
Lamello Zeta contest winners Bryan and Erin Kerr.

for our company, and it's awesome to incorporate it into some of the processes that we do. I mostly will probably use it for cabinetry and face frames, and miter pieces for furniture joints. It's an easy way to create those."

Kerr works with his wife Erin who is in charge of marketing and business development. The two work as a team of owner/operators, creating fine woodworking proj-

ects for discerning clients throughout the region. Prior to Helene, the two were part of a co-op shop, Foundation Woodworking, in Asheville's River Arts District, where they worked alongside 10 to 15 full-time woodworkers. The entire Foundation complex was destroyed by 16' of water.

Colonial Saw is the exclusive U.S. importer and distributor of Lamello products since 1974. Learn more at csaw.com. **W**



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Butternut supply continues to dwindle

By Jennifer Hicks

Often referred to as "white walnut", butternut (*Juglans cinerea*) has its own unique place in the hardwood market. It's soft, easy to work with and can display a visually striking grain pattern that makes it an ideal pick for furniture projects. But with the butternut canker disease causing a rapid decline in the tree population, supplies are limited, according to suppliers interviewed by Woodshop News.

"The butternut canker is basically going to wipe out butternut nationwide, eventually. There's butternut still up in northern Wisconsin, but where I am, there's no butternut left," says Michael Johnson of Johnson Creek Hardwoods in Mount Carroll, Ill.

"That isn't to say I don't have some because years ago I planted some butternut and I watched how quickly it grew. I thought I had died and gone to heaven. But after about 15 years, it all got the canker and died. But some of it was big enough, because it grows so fast, that we did get some nice lumber out of it. But otherwise, it's gone in my area completely, and I think most of Illinois."

Butternut canker has spread throughout much of the tree's range in the U.S. and Canada. The rapid demise of the species has caused the U.S. Fish and Wildlife Service to declare the butternut "a species of concern," according to the Global Invasive Species Team at The Nature Conservancy.

"We don't have anyone asking for butternut anymore. I think everyone just assumes that it's gone," says Johnson. "It's got a gorgeous satin finish when you sand it and finish it, but people are just on to other things, like walnut and white oak."

"It's a great all-around wood," adds Luke Zale of Rare Woods USA in Mexico, Maine. "It's very porous so it does



accept finish very readily. There's a good amount of chatoyance in the species when you have a nice surface on it.

"We've carried (4/4) butternut for about four to five years now, and we had to resupply last year. It was awfully hard to find a good supply for butternut and when we did find it, it was sub-optimal. They were pretty narrow pieces that we were able to find, where most of the time a 6" width or more is preferred. Unfortunately, all we could find on the market though was 4" widths, so I do think that the supply has taken a downturn. We haven't been able to find anything better than that in about a year or so." **W**

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Cantek America makes a panel beam saw for small- to medium-sized woodshops that comes in a number of size configurations.

Thinking about a panel saw?

Breaking down the available options and the advantages that shops of all sizes can expect

By John English

Breaking down sheet goods has always been a challenge for small woodshops. A 4x8 or 5x5 sheet of plywood or MDF is just about at the limit for one person to carry. Making them physically manageable is one reason that we cut big panels into smaller ones, but we also do it to optimize yield. While a portable saw with a guide rail is certainly a viable option, a panel saw can reduce the work by half because there's no need to spend time setting up sawhorses, or clamping and adjusting the guide, or figuring out how to catch the falling parts. And there's a lot less lifting.

Panel saws come in a huge variety of configurations, in part because manufacturers include sliding table saws and beam saws in the cate-

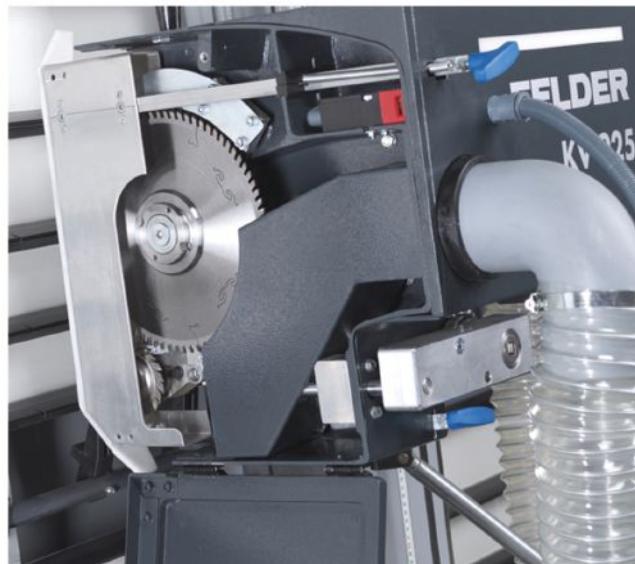
ry alongside horizontal and vertical panel saws. A vertical saw can be set up against a wall, so in theory it has a small footprint. But it also needs space along the wall on both sides (left and right) for infeed and outfeed, and space in front for the operator. That means the shop needs to have a long, obstruction-free wall available with room for traffic, too. But keep in mind that the panel is handled on edge rather than flat on one face, so the sheets themselves are occupying a lot less floorspace.

In large shops with high volume, a horizontal beam saw (and some come with the option of multiple heads) is a logical way to reduce panels. But that can be a much larger investment than a vertical panel saw, and much bigger physi-

cally, too.

Some manufacturers have come up with a third option – horizontal panel saws that are less expensive than a beam saw and still have some advantages over a vertical unit. For example, vertical saws usually can't make an angled cut across the face of a panel or deliver a beveled (mitered) edge. But a panel can be quickly clamped at an angle on a horizontal saw, and many of them can be tipped to bevel.

Horizontal panel saws look like a radial arm saw with a lot more travel. The arm is secured at both ends to columns that are several feet apart, and instead of the saw traveling toward and away from the operator the carriage moves from side to side. The movement is automated, so the



The new Felder KV 925 is a vertical panel saw that includes intelligent controls and a scoring blade assembly.



SawTrax offers a full line of panel saws, plus a kit for a shop-built saw and a basic unit without a saw that has sealed bearing guides.

woodworker secures the sheet to the bed and then stands back while the machine moves the blade.

HOW THEY WORK

Vertical panel saws offer an ergonomical way to handle large panels safely by minimizing the need to lift awkward and unwieldy stock. The operator only needs to place the bottom edge of the sheet on a ledge a few inches above the floor, and then almost effortlessly slide the panel left or right to locate the kerf.

These saws can be anywhere from very large and fully automated industrial machines to small portable units for jobsites and even come as kits and plans for shop-built versions. For example, **SawTrax** (sawtrax.com) offers a high-quality kit that includes the guide bars, guide anchors and carriage for shop-built versions that can range from 64" to 100". The company also makes a Basic Series body where the user supplies the saw. One feature of the SawTrax system not found in many small machines is a sealed bearing roller system for the carriage.

Vertical panel saws reduce the risk of kickback because for most cuts the panel isn't being moved. It just sits there while the saw blade travels through it. Full and partial panels are also physically restricted by the ways, which can stop cut-offs and parts from falling toward the operator. The ways are guide tubes or steel bars (usually round in shape) that use roller bearings to allow the saw to travel along them on a counterweighted sled, or carriage. The counterweight makes the carriage feel very light, which reduces operator fatigue.

Panel saws can make cuts very quickly, and unlike a table saw they fully conceal the blade while doing so. That means there's almost no chance of contact with hands. On most panel saws, one would need to



Colonial Saw distributes the Swiss Striebig line of panel saws that range from the entry-level Compact (top) to the fully automated 4D.

The horizontal panel saw range from Original Saw is marketed as a crosscut beam saw, which is perhaps a more accurate description.



Maksiwa calls its BMD3200IR a panel saw, and it comes with a CNC fence and a touchscreen control panel.



The SPN1 and SPN2 vertical beam saws from Hendrick Mfg. use a full-length pressure beam to hold stacked panels in place.



The SpeedWorx saw from Safety Speed Mfg. brings X, Y, Z and C automated controls to a vertical panel saw.

intentionally reach a long way under the carriage before being able to touch the blade. On most table saws, the operator can see the blade. On panel saws, it's obstructed by the carriage, the blade housing, and various dust collection parts.

A special jig is required to cut small panels safely on a vertical saw, and its role is to fully support and secure both the part and the offcut without the need for hands to hold anything. Trying to cut small parts without

such a jig is quite dangerous. Most of these jigs are shop-built.

The circular saw on vertical panel saws can rotate 90 degrees on its carriage and be locked to that orientation. The carriage can in turn be locked in place at a specific height along the ways, so that parts can be fed sideways into the stationary blade to make long horizontal cuts. In this case, the saw stays still while the panel moves, and gravity keeps the panel down on the bottom roll-

ers. Such cuts are often referred to inaccurately as rip cuts, despite the fact that panels rarely have a grain pattern so they're not being ripped along the grain. With the saw reset to 0 degrees, the vertical capacity of most saws exceeds the width of a sheet (48" or 60"). In this case the saw moves, and the panel stays put (and yes, these vertical cuts are often called crosscuts even though they don't travel across grain).

The concept of the saw moving and the sheet remaining stationary is one of the biggest advantages of a panel saw over a table saw. It completely removes the uneasy feeling of trying to manipulate and maneuver a full sheet of plywood across a table that is smaller than the material while simultaneously holding the sheet's edge against the fence and trying to hold it down on the table and on track with no wavering, so it doesn't bind, bite and kick back. Whew!

We've all been there, and we've all been nervous.

There are few disadvantages to vertical panel saws. Some lighter models can go out of alignment when large and heavy sheets are loaded roughly, or the saw sees infrequent maintenance. The guide tubes are adjustable so they can be locked in at exactly 90 degrees to the bottom rollers and that mechanism can work loose over time, making vertical



Two Gabbiani panel saws from SCM Group, including the VSi shown, have independent motors for the main and scoring blades.

18 cuts a degree or two off true. Something to watch for.

Some vertical panel saws can accept carriages for routers, knives (for foam or foil), and other tools. And some offer more dust collection than the single port on the circular saw's blade housing, so that's worth adding to the shopping list. A few smaller panel saws are designed for jobsites but advances in high quality track saws may make that unnecessary.

Many vertical panel saws are on wheels and light enough for one person to move. Highly accurate measuring and stop systems for repeat cuts are also available.

SOME OPTIONS

Automating panel reduction by combining robotic loading with a beam panel saw is an obvious solution for larger shops, and Stiles/Homag has posted a video of this. Search for Oofn-Jq2lyaw on YouTube.

Cantek (cantekamerica.com) makes panel beam saws called the TPS-CSR series that come in 8', 10' and 12' versions.

The **Original Saw Co.** (originalsaw.com) offers a range of horizontal panel saws which it calls crosscut beam

saws. The blades are from 16" to 22-1/2" and the travel is up to 64", so it can handle 5x5 plywood.

Several manufacturers describe their sliding table saws as panel saws, which is an apt description for those units that are capable of handling full sheets and supporting the cut-offs. Saws such as the BMD.3200.IR from **Maksiwa** (maksiwa.com) come with CNC controlled fences and touch-screen controls.

Some vertical saws have scoring, such as the TS series from **Castaly-Lobo Machine** (lobomachine.com) that also have variable speed, automated clamping, and a control feature that lessens the travel on smaller parts to save time.

The **Felder Group** (felder-group.com) makes a full range of horizontal beam saws and the new KV 925 automated vertical saw comes in 4x8 and 5x10 versions. It has advanced dust collection, a scoring blade, and even an intelligent support system where various parts move in sequence to avoid being cut.

The **Safety Speed Mfg. Co.** (safetyspeed.com) also offers a wide range of vertical saws including the Speedworx Automated Panel Saw, which has touchscreen controls for X, Y, Z and C movements.

For medium to large woodshops, **Hendrick Mfg.** (hendrickmanufacturing.com) makes half a dozen horizontal beam saws and two vertical units, the SPN1 and SPN2. Both machines use a unique full-length pneumatic pressure beam to clamp stacked panels across the entire cutting area.

For smaller shops, retailers such as **Woodcraft Supply** (woodcraft.com) and **Rockler** (rockler.com) offer saws from manufacturers mentioned here such as Safety Speed and SawTrax, plus the Powermatic PM9 vertical panel saw.

SCM Group North America (scmgroup.com) carries an extensive catalog of horizontal beam saws and four vertical panel saws from Gabbiani, such as the VSi and VS models that have independent motors for the main and scoring blades.

Colonial Saw (csaw.com) is the authorized U.S. and Canadian distributor of Striebig saws, and the company has dealers throughout North America. The machines are manufactured in Switzerland by a firm whose only business for the past 60 years has been building vertical panel saws. Striebig makes manual, semi-automatic and fully automated models. **W**

Hettich adds a twist with FurnSpin

By Jennifer Hicks

Hettich America has introduced FurnSpin to the U.S. market. The hardware system allows cabinets to swivel and rotate 180 degrees in a stylish and effortless fashion, according to the company.

"The impact of FurnSpin is best felt at your fingertips," says Matthias Bertl, CEO of Hettich America.

"With a simple, graceful twist, an entire cabinet body effortlessly rotates to reveal open shelving, transforming storage into a design statement. Our engineers have perfected the balance and kinematics to such a degree that FurnSpin operates with just the strength of a pinky, moving with exceptional precision to keep even the lightest, most delicate objects securely in place. We can't wait for consumers to experience the Hettich difference and for designers, architects, and specifiers to reimagine high-end storage solutions with this game-changing innovation."

FurnSpin builds upon the technology of the company's ComfortSpin, a rotating shelf that brings items stored in the back to the front.

"The hardware's torque is precisely calibrated, ensuring stability even for delicate items like fine glassware, and has no visible hinges or handles, unless desired, for a sleek design," the company said.

Each FurnSpin set includes top and bottom fittings with



A bathroom cabinet outfitted with FurnSpin from Hettich turns to reveal open shelving on two sides.

the option for clockwise or counter-clockwise spin configurations, available in three sizes to accommodate various cabinet dimensions and applications.

The compact FurnSpin S offers a 13-3/8" width and depth, with a maximum height of 78" and a load capacity of 175 pounds. For medium-sized applications, FurnSpin M offers a 15-7/8" width and depth, a maximum height of 86", and a load capacity of 220 pounds. The largest option, FurnSpin XL, offers a 20-3/4" width and depth, supporting up to 260 pounds with a maximum height of 94".

Learn more at hettich.com. **W**

Guffey Systems debuts the Flex Spray Station

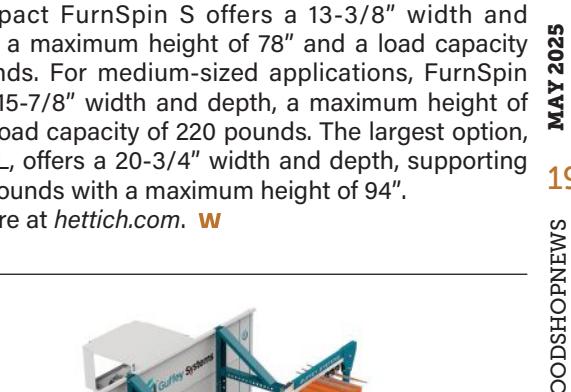
By Jennifer Hicks

Guffey Systems, a manufacturer of vertical finishing solutions, presents the new Flex Spray Station, a self-contained, fully assembled spray booth designed to help cabinetmakers and other woodworking professionals save time, boost efficiency and get top quality results, according to the company.

"We set out to simplify and speed up the finishing process for our fellow cabinetmakers," said Nathan Guffey, president of Guffey Systems, in a statement. "The Flex Spray Station embodies our mission to reduce material handling and rework, all while maintaining the high-quality finishes our industry demands. The system is a great fit for shops looking for a flexible and scalable solution for their finishing."

The system is mounted on locking casters and can easily be rolled into place and set up for operation in less than half a day, the company said.

Features include galvanized steel construction, an in-



The new Flex Spray Station from Guffey Systems.

tegrated exhaust system, and user-friendly features to easily switch between water- and solvent-based coatings.

"When using water-based coatings, the booth functions as a self-contained recirculating system; optimal ducting kits make venting solvent-based coatings simple and efficient," the company explained.

The system is available as a spray booth only option or in three kits configured for shops of varying sizes and volumes. Each kit includes rail systems, rolling spray hubs, and hangers that can handle 20 to 40 parts at a time.

The Flex Spray Station starts at \$11,900. Learn more at guffeysystems.com. **W**

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TOOLS & TECHNIQUES

Maksiwa adds a pair of edge banders

By Jennifer Hicks

Maksiwa presents two new 'compact' automatic edge banders, models CBC.TPM and CBC.PCR, designed to meet the demands of cabinetmakers, according to the company.

"Both machines offer different features depending on the customer's budget," says Vitor Saar, sales director at Maksiwa. "These models combine high-performance features with exceptional value, giving professionals the tools they need to achieve a better result."

The CBC.TPM can run banding from 0.4 to 2mm thick and on panels from 10 to 45mm thick. Features include



The Maksiwa CBC.TPM (left) and CBC.PCR automatic edge banders.

pre-milling, vertical rounding, glue scraper, and buffer unit. The measures 93-1/2" x 41" x 53".

The CBC.TPM is "an affordable, compact, edge bander that gives you pre-milling and other features found on more costly machines," says Saar. "This is coming in very aggressive for its price. Another great feature is the vertical rounding, which is not a corner round, but it gives you pretty much the same finish on the side of the panel, not on the full top and bottom corners. It's also beneficial for cabinetmakers with limited space."

The CBC.PCR can run banding from 0.4 to 3mm thick and on panels from 10 to 50mm thick. It features corner rounding and an XMelt gluepot, compatible with EVA and PUR glue. The machine measures 119" x 41" x 49".

"Compared to CBC.TPM, on the CBC.PCR you're getting an industrial machine," says Saar. "It's a little bit larger but still compact for an edge bander. It includes full corner rounding, something cabinetmakers like to see on a more professional automatic machine."

"It also has an extra-large gluepot with easy drainage, which is something people appreciate because whenever they want to clean the glue pot or change colors for the type of glue they're using, it's easier."

Both machines are single-phase and feature stand-by mode, centralized dust collection, and a PCL touchscreen display with diagnostic interface.

The CBC.TMP sells for \$21,900, while the CBC.PCR is priced at \$34,900.

Learn more at maksiwa.com. **W**

Felder to debut new edge bander at AWFS

By Jennifer Hicks

Felder has introduced a new automatic edge bander, the Tempora F1000, to its Format4 line, which is celebrating its 25th anniversary.

"The F1000 is a good representation of 25 years of putting machines in shops that are built for them. This particular machine is the current evolution of the entire line of the Format4 edge banders. While it has a lot of redesigns to it and new stations, we built off the feedback from the machines that we put into the market and customers' requirements," says Felder product manager Jesse Maynerich.

A highlight is a new top and bottom trimmer, which serves two functions in one.

"In the past, you would have one unit that would cut the top of the edging, and then one that would create the round over. This does all that with two independent heads, so you're taking away the top of the material where most of the stress is and then going behind that with a lighter touch, creating the radius. It's one step with two different heads. It's a valuable multi-function where everything moves more quickly and puts less stress on the workpiece," says Maynerich.

The F1000 has an installation length of 8000mm (26-1/4"). It processes edging from 0.4 to 12mm thick and workpieces ranging from 8 to 60mm in height, according to Felder.

Other features include a top-mounted, application-controlled glue pot; top pressure belt; end-trimming, pre-milling and radius scraping units; automatic lubrication system, and 18" 'smartouch' control screen.

The Format4 Tempora F1000 will make its U.S. debut at the AWFS Fair, July 22-25, in Las Vegas. It's available as a Classic, Professional and Performance version, starting at around \$250,000.

Learn more at felder-group.com. **W**

Courtesy of Felder



The Format4 Tempora F1000 edge bander.



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WOODSHOPNEWS

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Learn more at woodpeck.com.



NORTHPOINT CABINETRY,

a line of cabinets from Hardware Resources, has expanded to offer both QuickBuild and fully assembled cabinetry products. The assembled cabinetry is available in the full range of NorthPoint Cabinetry options and ships quickly nationwide, according to the company. Learn more at northpointcabinetry.com.

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introduces its new 15" benchtop planer with a spiral cutter-head, model G0999. Features include a 2-hp motor, two-speed gearbox, digital thickness readout, micro-adjustable depth stop, and the extra capacity to plane stock up to 15" wide. Other features include board return rollers, an easy-to-read cut depth scale, and grab handles for carrying. Optional extension tables are available. Learn more at grizzly.com.



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Matching the vision

Documenting the finishing process and making a step panel are keys to success

By Diane Shattuck

When you are ready to apply a finish, you should have a vision in your mind's eye of what the project will look like. The trick in finishing is getting that vision to happen.

Accurately understanding how color and the coatings respond to the wood substrate is critical. For example, changes to temperature and humidity can redirect what you had in your mind's eye as to how the coating will behave. Remember coatings do not have a brain, they are simply reacting to the circumstances that are pres-

ent at that moment. It is the job of a finisher to document our process and create a step panel so we can visually see and follow how our physical sample changed with each step. Using these two important tools will be our best chance to achieve what is in our mind's eye.

I'm often asked the importance of making step panels. Many feel that it will take up too much time and it does not really matter because as long as they perform the same documented process throughout a project, they

should have the same results. That couldn't be further from the truth.

For example, let's take a simple stained maple door with two coats of finish applied. The first door was sanded with a 150-grit aluminum oxide abrasive. It was stained within two hours of sanding and allowed to dry 45 minutes. Then the sealer was applied, dried for 45 minutes, sanded with 320 silicon carbide sandpaper, and top-coated within 30 minutes. The weather was perfect: sunny, 82 degrees F, with a gentle warm breeze.

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- Karl Brogger, Sogn Cabinets

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The second door was done the exact same way, but it was cold and rainy. The door turned out blotchy. The sealer didn't sand as smooth or dry in the same time frame. The color is off, and the final coat has orange peel and a slight blush. The blush and orange peel were due to the temperature and humidity change, which also affected the dry time and sanding results.

All of this would have been caught by the visual storyboard, not by just

doing the recorded process.

Without the use of visual step panels and Standard Operational Procedures (SOP's) you will have consistent inconsistencies, meaning things will continue to happen even after tweaking systems and products during application with the thought that the problem was fixed. Understanding the substrates, products, equipment, and environmental coherence to each other is key to fixing the problems and

gaining consistency.

The process of making the step panel not only helps you develop the color but also offers us rich data when developing the system of our finishing schedule. Documenting every step and condition at the time will help treat any trouble or inconsistency as valuable data. If there is trouble occurring in any step, we have information to review about the process, materials and the people involved. This will save us the trouble of the same problems occurring later in the actual finishing process.

How do we begin to lay out our step panel or tell our story? We do so by first using the cut-off materials from our project, so that you have the best representation of natural color, grain, texture and density of the substrate we are working with. This way you can get the same reaction that will happen on your final project. Don't use a scrap piece from a past project since it may not have the same characteristics.

After sanding the panel, place a strip of tape down marking off a portion off the top of the board to preserve not only the original color of the raw wood but also how it was sanded. Next, apply a dye, stain, primer or washcoat and document how long it was allowed to dry. Place another strip of tape over that, move to the next step, and so on. You want to place a strip of tape over each step taken to show the process and how the color is shifting through each application, all the way to the final coat of finish while also documenting time frames and process. Remember even though a clear finish is "clear" it still can have an amber, pale yellow, very pale grey or blue cast that will affect the final color.

Once the entire system is completed on your panel, remove all the tape. You will now have a visual step process to check against as you work on your project to make sure you stay on track. This is now your story and you're sticking to it! If at any point in your finishing process you tend to stray off color or appearance, that is when you want to fix it. Not when you have already applied the final coat.

The importance of the SOP paper-

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work is to document the entire process. Record temperature, humidity, how you sanded the wood, when you sanded, how and what stain you applied, how long you let it dwell before wiping off, how long did you let the stain dry before sealing it, how long the sealer dried, the type of equipment used (tip sizes, air pressures), wet mils applied, sandpaper grits, and time between steps.

Much of the process is spelled out in the manufacturers' technical data sheets. Take some time to look them over to have a good idea where to start and adjust for personal needs.

Just using one or the other does not guarantee you will achieve your desired results. Using both will. It's like cooking from a recipe of ingredients and watching a video that shows you

how, which is way easier.

Remember to trust and respect the process and always stick to your story. **W**

Diane Shattuck is a finisher, consultant, guest speaker, writer and teacher. She can be contacted at dianeshattuck@msn.com. Questions, suggestions and comments are always welcome.

IWPA HONORED FOR E-LEARNING PROGRAM ON LACEY ACT COMPLIANCE

The International Wood Products Association (IWPA) has received the Gold TRENDY Award for Best E-Learning and Live Training Program at the 2025 Association Trends Salute to Association Excellence. This award recognizes IWPA's commitment to industry education and its success in equipping businesses with the knowledge and tools needed for compliance with the Lacey Act.

Funded through a grant from the U.S. Department of Agriculture's Animal and Plant Health Inspection Service (APHIS), IWPA's training

program provides on-demand, hybrid, and in-person education to businesses impacted by the Lacey Act's evolving regulatory requirements. Through its five-module Lacey Act Due Diligence Course, specialized service provider training, interactive hybrid discussions, and targeted compliance workshops, IWPA has helped over 1,500 industry professionals navigate regulatory complexities and implement effective compliance strategies.

"We're honored to receive the Gold TRENDY Award as the result of our

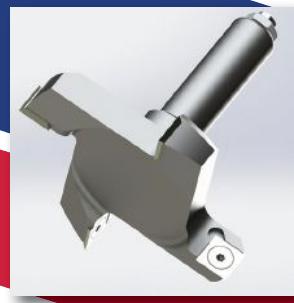
commitment to regulatory education and supporting industries impacted by the Lacey Act," said Ashley Amidon, Executive Director of IWPA. "Thanks to APHIS's generous support, we've developed a comprehensive training program that empowers businesses with the knowledge they need to comply with federal regulations while continuing to source and distribute wood products responsibly."

Learn more about IWPA's Lacey Act Compliance Training Program at iwpawood.org.

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A project for Quinnipiac University's
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Courtesy of Zavarella Woodworking



Alex (left) and Bruno Zavarella in the shop's design room.

ON A PATH TO MORE GROWTH

Zavarella Woodworking is heavily focused on commercial projects and manages all aspects of jobs from plans to installation

By Jennifer Hicks

MAY 2025

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WOODSHOPNEWS

Zavarella Woodworking in Newington, Conn., has excelled at custom architectural millwork and commercial installations over the past several decades. The union-affiliated company started as a small two-man shop in 1987 before incorporating in the mid-90s, when it expanded offerings and focused heavily on growth. Currently at about 45 employees, founder and president Bruno Zavarella wants to increase volume by hiring all around.

"We're trying to get a younger workforce in here to learn and be able to have security in that aspect with younger people not on the verge of retirement that can grow with the company. We want them to learn the expertise from the people with many years in the industry and

also be energetic to expand with the growth of the company. We're hiring some people in the shop, some in project management, and looking for some people in the engineering department," says Bruno.

Bruno is joined in company leadership by his son, Alex Zavarella, who helps manage the day-to-day operations and serves as a project manager. Their 27,000-sq.-ft. facility is set up to streamline a full gamut of services, from engineering and design through custom finishing.

GETTING STARTED

Bruno dabbled in woodworking as a teen, and by age 20, entered the trades.

"I went to school for electronics and got into the sign business working for another company. I started making signs, and since I knew the wood-

working business, I started refacing kitchens and doing countertops out of my parents' garage in Newington."

He partnered with his brother, Vinnie Zavarella, to start a sign making and woodworking business in Berlin, Conn. The pair eventually split the businesses into two, with Bruno incorporating Zavarella Woodworking in 1994. In 1998, he purchased the land for his current facility and built the original 6,000-sq.-ft. shop.

"From 1994 to 1999, I was doing a lot of residential work. I was drafting, fabricating, finishing, and doing everything myself with some small hands around the shop here and there and basically doing the installs. As time went on, we started to get into commercial work. Around 1997, the projects started to get larger, and I started to bring on more full-time employees."

Alex started in the family business



Bruno Zavarella inspects a cabinet frame with Jeff Rulli (yellow shirt); Troy Mitchell (right) prepares a panel in the assembly area.

in 2003 while still in high school. He went to college for project management, starting at Wentworth Institute of Technology in Boston before transferring to Central Connecticut State University in New Britain. He joined Zavarella Woodworking full time in 2009.

In 2014, Alex was put in charge of a newly created unionized subsidiary that handled installations, Architectural Millwork Installers (AMI).

"We found ourselves exposed to a lot of larger projects, which were controlled by general contractors who were signatory to the carpenters' union," says Bruno. "So, they required union carpenters on their jobsites. Since we weren't union, I would have to sub out those installations to other union installation companies. I did that for a while and found it to be a problem. It was difficult to work with subcontractors. So, with Alex, we both decided to open a union company (AMI), in which Alex became the owner."

Under the arrangement, Bruno hired Alex for installations rather than outsourcing to union installers. That lasted for about four years until the father-and-son team decided to go all union.

"In 2020, we decided the best plan of action going forward would be to dissolve AMI and become an all-union shop, and we were able to grow from there. At the end of the day, we're proud and happy that we joined the union," says Bruno.



They started with the New England Regional Council of Carpenters, which became the North Atlantic States Regional Council of Carpenters in 2022, which covers New England and parts of New York and New Jersey.

Bruno says unionizing has been beneficial in many ways. "There are better labor force opportunities, also access to larger projects. It's a growth thing for sure. You have the ability to hire people that install your work at a larger capacity than you would if you weren't signed on."

A BROAD MARKET

The shop's geographic radius generally includes Connecticut, New York, Massachusetts, and Rhode Island.

"We'll go as far as Poughkeepsie (N.Y.) and as far as the top of the Bronx, out to Providence (R.I.). We do all of Connecticut, even some parts of Long Island and all the way up to Boston," says Alex.

Commercial customers include event centers, universities, corporate spaces, healthcare facilities, hotels, restaurants, schools, Marine bases, and the National Coast Guard Museum in New London, Conn.

"The reality is we do it all. We work in all sections, but our big niche is our universities, corporate, and healthcare. Our primary work is in Connecticut, mostly Stamford, Greenwich, and New Haven, but we're floating all over," Alex says.



A food service counter, also for the Quinnipiac University project.



An illuminated desk for Technolutions in New Haven, Conn.

"Our direct clients are general contractors. They're not really GC's anymore, they're construction managers because they don't sell or perform work. Most of them, probably about 75 percent of the people we work for, they manage the work for the owner. They work for the hospital, maybe the state of Connecticut, the township or whatever, and they facilitate all the subcontractors to get the job done."

Bruno says he weaned the company off residential work decades ago. "Residential work is a different kind of infrastructure. You need to kind of sit with a customer and help them understand what their job is going to look like, hold the customer's hand with colors, things like that. You're a designer at that point."

"In the commercial industry, all that's left up to the architect and you're just basically bidding the job based on plans and specs and going from there. Basically, you're going up against those drawings, competitively bidding the job, and once you get the project, you just run from there. The other part is that residential work is one job here and there, and the volume of that would be 1/10th of the size of the jobs we get right now, so you'd need to have a whole lot more work in order to do it."

READY FOR MORE

On average, the company completes about 30 substantial jobs a year. It has four project managers, three estimators, and three drafting engineers.

"We spent the last couple years building the footprint of what we need to do the larger projects as far as how we compartmentalize, our management system, our information flow, and also how we handle the field work, and having foremen and crews and things like that. Now it's just a matter of getting the right amount of volume for those individuals to handle all that overhead," says Alex.

"We expanded, hired the right people to manage the work and now we're getting all the work. We just want more of a steady volume of that level of work, and we can fit more capacity right now."

Bruno says there's plenty of work ahead to look forward to.

"Last year we saw a little bit of a slowdown because it was an election year. It was kind of bogged down in the later part of the year, but we see it definitely turning now. I would say we've been consistently growing in all aspects of volume and efficiency for the last five years. There's lots going on right now and things are popping up constantly," he says.

Bruno also says he wants to keep growing and double company's gross is the next five years and adds that there's no cap on how much he would want to expand.

"I don't think there's really a limit. It's just a matter of how the flow goes. As long as you have the tier aspect where you're able to delegate and it works, then why not grow?"

Learn more at zavarellawoodworking.com. **W**



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Cabinet Vision contains several modules such as xOptimizer, which allows users to convert cut lists into patterns that optimize material usage.

Keeping pace

CNC software providers are answering the bell in their hi-tech race

By John English

CNC software for woodshops is trying hard to keep pace with emerging technologies, but it's a challenge. Software suites are updating features such as remote machine monitoring and control, trying to provide a more user-friendly way to interface, increasing automation apps that make better use of robotics, accommodating technologies such as 3D printing and digital twinning, and using artificial intelligence (AI) to assist with maintenance monitoring and quality control.

While technologies such as AI and robotics are demanding state-of-the-art software solutions, there are other forces in play here, too. From a woodshop owner's point of view, the demographics of the U.S. labor pool are a problem. Many potential employees are either devoid of relevant skills or too highly skilled to be affordable. There are very few applicants with the competency and training required to operate CNC routers and similar machines. The bottom line is that it's still hard to hire.

Software and automation can be used as a partial response to labor

shortages by replacing humans who are performing basic or repetitive tasks. There is no doubt that automation increases volume while reducing waste and rework. But there is still an immediate and desperate need for training facilities nationwide where smart young people can learn the CNC software skills required to operate the next generation of woodshops.

THE LEARNING CURVE

Software publishers recognize this need for training, and they're responding well. For example, Cabinet Vision from **Hexagon** (hexagon.com) offers online tutorials, webinars, in-person training and interactive sessions that can prepare new users and also refine the competencies of existing users. One advantage of this trending increase in knowledge sharing, and in support generally, is that woodworkers not only learn how to integrate software with the shop's machinery, but also with other programs. Cabinet Vision users rely on the basic program to translate box, door and drawer designs into machine-ready CAM, but they can also

turn to another Hexagon package, Alphacam, to tweak fine details and design complex or decorative elements. Improved training support is making it easier for woodworkers to learn multiple programs and then tie them together to create more sophisticated solutions for clients.

That process is called integration, and a good example of where it's going is the new cloud-connected platform from Hexagon and Microsoft called Nexus, designed to help businesses such as cabinet shops get the most out of AI.

KCD Software (kcdsoftware.com) defines vertical integration as "allowing custom shops to move into manufacturing, optimization, laser measuring, and component outsourcing systems at their own discretion and at their own pace." What it's actually doing is letting CNC software programs 'talk' to the shop's machines and coordinate with outsourcing partners. The more automated the communication, the less training the shop's crew needs.

Microvellum (microvellum.com) offers training videos, sample projects, quizzes, community forums,

and knowledge base articles to its clients through an interactive collective called the Microvellum University. The company's CNC software is AutoCAD-based, so it has a relatively steep learning curve that includes becoming familiar with elements of the underlying program. However, the end result for woodshops that invest the required time on that curve is a very powerful suite of tools that can deliver highly customized solutions for shops to build beyond basic boxes.

PRICING ISSUES

Business software packages such as spreadsheets, CRM and ERP have trended toward denying clients the option to buy programs outright over the past decade. Annual fees are the new norm. But a different trend has emerged among CAD/CAM software publishers, where the impetus seems to be on providing more ways to purchase. Those include renting/leasing, but there's also a strong emphasis on buying and renting to own.

It's usually less expensive to buy a package outright rather than paying a monthly or annual leasing fee. But while a one-time purchase may seem sensible, leased software will always be more current due to constant updates and tweaks. Whether a woodshop needs every new tweak is questionable.

Charges for product support are lower or non-existent with a lease, while shops that are buying may see a pay-per-use option offered for support. Most publishers still charge for installing a leased product on more than one computer or device, and those fees can add up if the shop owner, designer, foreman and salesperson all need access to the design software, and some use more than one device. So, when looking at pricing, it's important to consider such fees.

Buying a package that includes live technical support can make the difference between getting a job out the door on time and missing a deadline. If there's a glitch that could be fixed in minutes with a phone call,



Courtesy of CabMaster
CabMaster and other programs are now able to import everything from built-in ovens, countertop hobs, stools and lighting from supplier libraries.

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CNC rendering is becoming more photo-realistic, as seen here in a Cabinet Pro image that shows the ability to draw organic grain matching.

36 paying for live support outweighs the downtime involved in searching for solutions without expert help.

Some of the more enlightened publishers recognize that shop owners need to be able to choose. For example, **Microvellum** offers both an annual subscription option that includes uninterrupted service, continuous updates, support, and new features throughout the year and a one-time purchase option that provides lifetime access.

While most programs include a post processor, if a woodshop has more than one CNC machine, each will need a separate processor and the cost for this can add up. According to CNC manufacturer **Tormach** (tormach.com), "post processors act as a translator from your CAM to creating G-Code that is specific for your machine make and model. Even when two machines are very similar in size and capability, it is rare that the same post processor will work for two different make/model machines." Just another issue to address when buying CNC software.

It's possible to set up CAD and even CAM without paying a leasing fee. For example, **Hexagon's** Autodesk Fusion 360 offers a free CAM software option for CNC machining and 3D printing that's available to

students, hobbyists and educators. So, with Fusion for personal use, hobbyist users can access free CAM and CAD 3D modeling. But commercial woodshops are probably best served by jumping on board with relatively inexpensive, comprehensive CNC software packages that include training and support along with frequent updates. Robotics, AI and other technologies such as 3D are picking up speed, so this may not be a great time to get left behind.



The latest version of CabBuilder includes a more consistent, user-friendly layout, so that the tools and menus become familiar faster.

WHAT'S AVAILABLE

KCD Software offers four pricing options based on a woodshop's needs, all of which include free tech support. The basic Designer package (\$99 a month as of mid-March 2025) includes 2D and 3D design tools, elevations and floorplans, dimensioned drawings, realistic 3D rendering, more than 300 door styles, wood grains, molding profiles, a means to create a custom library of cabinets, and several other features including live phone support. The next step up, the Professional package (\$128), adds estimates, proposals, reports, and the ability to integrate with Cabinotch and order RTA boxes. The Workshop option (\$168) adds cut lists plus door and drawer ordering, and the Commander (\$295) can design to CNC code, perform true shape nesting, and delivers one-button machining.

Cabinet Pro (cabinetpro.com) offers an all-in-one CAD/CAM solution that includes detailed shop and finished drawings, floor plans and 3D renderings, elevations, unlimited user-defined cut lists, material and door reports, bidding and invoicing, panel optimization, and automated Smart CNC processing. The company's purchase and renting options are designed to make CNC technology affordable for even one-man cabinet shops. The monthly charge for the Cabinet Pro CNC suite in mid-March this year (2025) was \$140 a month on a 12-month basis, and a package that also included Door Pro CNC was listed at \$201 per month.



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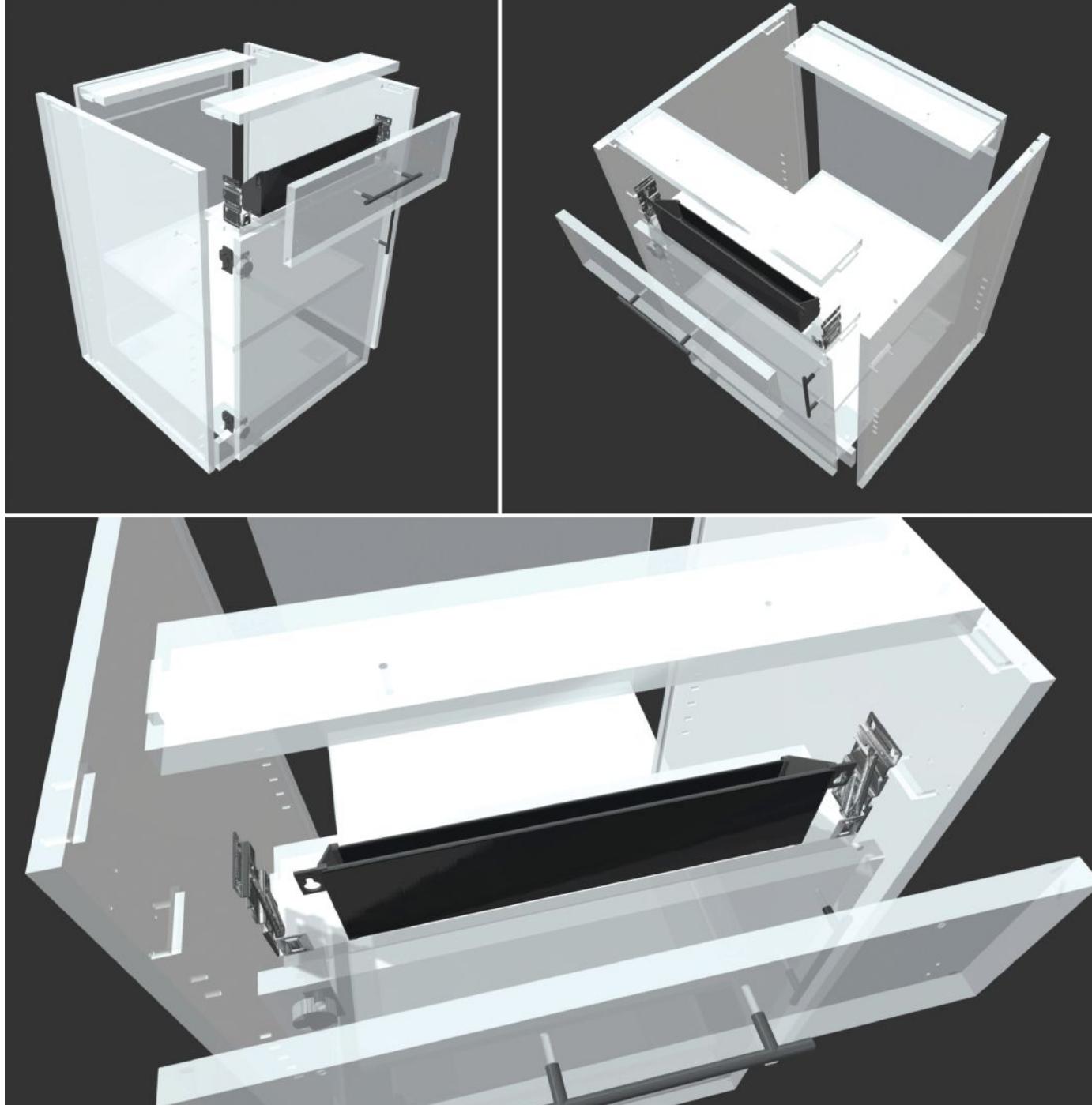
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Microvellum has the ability to rotate images 360 degrees, such as the new Rev-A-Shelf tip-out tray that is shown installed in a base cabinet.

Microvellum packages include CAD for design, drafting and shop drawings; MFG which integrates the drawing and modeling tools of CAD Toolbox with additional features for non-CNC manufacturing workflows, and CNC, which essentially automates manufacturing. The suite is very versatile with dozens of modules available that handle everything from nesting to labeling, grain direction controls, material handling (works with Biesse Winstore), post process-

ing, CSV file importing, optimization and more. It also includes an extensive frameless cabinet library that can be expanded to include face frames, closets, office furniture, bathroom partitions, and even staircases.

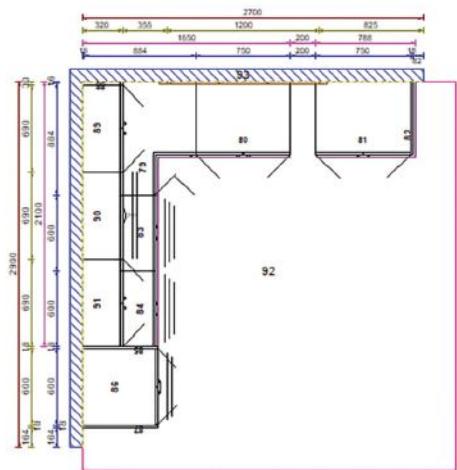
Mozaik (mozaiksoftware.com) provides a package called Mozaik CNC that starts at \$195 a month and includes designing, pricing, plans, cut lists, hardware lists, true-shape nesting, G-Code creation, post processors, CNC MDF Doors, CNC Dove-

tail Drawers, and more. And as with most of the leading CNC software packages, Mozaik also stresses improved integration, offering preloaded tools from brands such as Vortex, Royce Ayr and Great Lakes Custom Tool. For drawer boxes and trays made in the CNC Dovetail module, Mozaik comes preset with tooling and also offers the ability to set up flat-bed CNC dovetail tooling and drawer box parameters.

Based in Australia, **CabMaster**



An AI-generated kitchen design (top) and screenshot of a kitchen floorplan, elevation and rendering done with CabMaster's design software, which includes job details and material specs.







	CUSTOMER: _____	PHONE: _____	JOB NO: 1005 SCALE: 1:34 DATE: 15/04/2020 DRAWN BY: Designer Page 1 - Plan	
	SITE ADDRESS: _____	SUBURB: _____		PCODE: _____
	CONTACT: CabMaster	PHONE: _____		MOB: _____
	HEIGHTS: [Overall Job: 2400mm] [Floor Cabinets: 900mm] [Wall Cabinets: 720mm] < Doors 1220mm	DOOR 1 UPPER: 18mm New Antique White Laminate		
	INCLUSIONS: <input type="checkbox"/> Delivery <input type="checkbox"/> Demolition / Removal <input type="checkbox"/> Install <input type="checkbox"/> Other _____	DOOR 1 LOWER: 18mm New Antique White Laminate		
		PANELS: 18mm New Antique White Laminate		
BENCHTOP: 30mm Black Marble Laminate Worktop				
KICKBOARD: [140mm H] - 16mm Carcass White				
RUNNER: Blum TandemBox K 30kg Screw Front Board Back				
DOOR HANDLE: CabinetWare - Handle - Box Handle 128mm Chrome				



This built-in buffet by Hipp Cabinetry & Construction in Minnesota is shown installed, and also in two realistic renderings in a KCD design file.

(cabmastersoftware.com) also has offices in Santa Barbara, Calif. The company has been serving the cabinet industry since 1982 and provides separate suites for building boxes and making cabinet doors. The namesake CabMaster program has design to manufacturing CAD/CAM tools, including easy drag and drop features, a large library of cabinets and closets, the ability to create complete architectural grade drawings, photo-realistic renderings, cut lists, quotes, optimizing and CNC nesting.

Packages include design only, panel saw software, and a design-to-CNC suite that runs \$249 a month.

CabBuilder (cabbuildersoftware.com) has released its latest suite (Version 1.3.5/1.3.6). The Michigan software company is keeping right up with trends as it now offers a remote logout option that is not only convenient but also helps prevent data loss and overwriting. Cabinets can now be saved directly from design to the library, either as a modification or a new design. And the editing commands are now more in line with each other, so that users enjoy more familiarity, consistency, and intuitive responses as they move from screen to screen. All of these improvements are in tune with a trend in CNC software across the board toward a more user-friendly, simplified interface that requires less training and a shorter learning curve.

Mastercam (mastercam.com) is a CNC software program developed by CNC Software in Connecticut and used by machine builders such as **Thermwood** (thermwood.com). In keeping with the trend toward user-

friendly solutions, Mastercam modifies toolpaths automatically as the wood-worker draws. And it is expandable, from basic boxes to the most intricate 5-axis machining. The latest version, Mastercam 2025, includes features such as the ability to add high-speed finishing passes along selected toolpath boundaries, and to create toolpath planes with the correct tool orientation and spindle origin while taking advantage of the latest advances in Y-axis tool technology.

TASK-SPECIFIC TOOLS

Three programs from **Vectric** (vectric.com) are especially useful in smaller shops that need to design carved or ornate parts. Cut2D is a vector drawing and editing software package with 2D machining strategies for CNC routing, milling or engraving. Many programs such as AutoCAD, SketchUp and Fusion 360 use vector rather than pixel methodology. Vectoring creates images that are built with mathematical equations and geometric shapes, so they can be scaled and enlarged without giving up any definition (they don't get bit-mapped). Vectric's popular VCarve program uses similar technology to create 2.5D carving (2D images that simulate true 3D), and the company also publishes the pro level Aspire, which adds 3D tools.

EnRoute from **Sai** (thinksai.com) is a suite of CAD/CAM tools for CNC production. This again is vectoring design software, but it also offers material-saving nesting algorithms and automatic tool-pathing. In August 2024, Sai released a new suite of EnRoute tools that include the abil-

ity for objects and their associated toolpaths to remain on their respective layers post-nesting, preserving the integrity of the design; support for double-sided machining and accurate realignment when parts are flipped; the option to trim and extend contours by a set length; a way to automatically create output files for each tool used in woodshops that don't have an automatic tool changer (ATC) on their CNC; the ability to generate detailed PDF reports during output, complete with cut time estimation, tool lists, and barcodes; and improved kerf compensation where the corner entry/exit will now default to the sharpest corner of the geometry, optimizing kerf toolpath placements for superior cutting results. And this is another software supplier that has geared up support and training by hosting an online community and offering access to e-courses, virtual training and onsite training.

The new Router-CIM version from **CIM-TECH** (cim-tech.com) provides cabinetmakers with an automated CAD/CAM programming solution inside AutoCAD that can be used to create single parts and nesting. It automates scrap management, offers customizable labeling solutions, creates comprehensive production and yield reports, and provides detailed toolpath and nesting simulation.

Eurosoft (eurosoftinc.com) publishes the BlueCell software package for optimizing, nesting and automation. It can explore hundreds of thousands of solutions in just a matter of seconds to produce optimized patterns that can be transferred directly to panel saws and routers using Euro-



Two kitchens designed in Mozaik show the ability to add features such as LED lighting and open shelves and draw complex architectural details.

soft post-processors. These in turn then generate cutting instructions for machines in their own native language, and the post-processing eliminates the need for time-consuming and error-prone manual programming. BlueCell is another example of the trend toward more integration: it can import data from a woodshop's existing design and cut-listing software for more precise, customized optimization and nesting solutions.

NUM CNC (num.com) offers a wide range of products for the automation of CNC machines. Its NUMwood division is not limited to a specific type of machine, but supports joinery centers, machining centers, routers, lathes, gantry machines and through-feed machines to name a few.

RouterCAD (routercad.com) is an all-in-one software solution for cabinet, door and drawer design. It provides detailed access to a CAD-based drawing engine, cabinet libraries, cross sections, assembly sheets, material optimizer, custom report center, cabinet and part labels, and submittals and title blocks.

Last October, **3ERP** (3erp.com) predicted that "the future of CNC ma-

ching will see a significant shift towards remote monitoring and control, driven by advancements in IoT and data analytics. Remote monitoring allows you to oversee CNC machines from anywhere, using real-time data to track performance and detect issues before they lead to downtime."

Most analysts and commentators in this sector would add that the strongest trend in CNC software is integrating AI and machine learning (ML) into tool-pathing, maintenance monitoring and scheduling, micron-scale machining, and quality control.

Micron-scale software delivers results that are measured in microns (μm), which are just one-millionth of a meter in diameter. That's obviously many, many times finer than the results required in woodworking, but the technology is influencing how material expansion, vacuum clamping, flex in tooling, wear on CNC router parts and other issues are being addressed as automation increases. Each of those areas contributes to a level of inexactitude that is finding less and less tolerance as machines replace humans on the shop floor. **W**



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More to choose from

From decorative to functional, hardware manufacturers have been busy with new product introductions

By John English

Decorative hardware can be a challenge for woodshops. It's fickle and follows trends quickly, because it's easy to change. Pulls and knobs are also very tactile: after all, they're the part of the cabinet that we touch the most. So, showing a client a collection online isn't as effective as having physical sample boards available. The samples have weight and sheen that just doesn't translate well in two dimensions.

The challenge then is, what do you put on those sample boards?

The hot trends in decorative hardware this year, according to Kate McGregor at *House Beautiful*, are wooden knobs; black stainless finishes; brushed and polished metals together; round shapes such as circles and ellipses; statement hardware that stands out rather than blends in; lots of color; a vintage look; and elongated pulls. Rebecca Norris from the style and home magazine *Veranda* adds white metals, hammered knobs and pulls, chic dropped pulls, organic cast hardware, and plated pulls. And Helena Madden at *Martha Stewart* notes that sculptural hardware is hot.

DECORATIVE HARDWARE

The stunning new Modern Metal collection from **Richelieu Hardware** (richelieu.com) embodies almost every attribute the magazines mentioned, including brushed and polished metals, round shapes, color, high drama and sculptural forms. Part of the Rialto Collection, these pulls and knobs are inspired by Italian fashion and were in fact designed in Milan. With its contrasting colors and soft curves, Modern Metal is a blend of innovation and skillful, elegant craft.

The Jeffrey Alexander hardware brand was



Blum has added HL (up and parallel to the cabinet), HS (up and over the cabinet) and HF (folding as it moves up) options to its Aventos top system.



Berenson's Folklore collection (left) evokes a bygone era, while the knurled bars and smooth posts of Radial Reign are very contemporary.

founded in the late 1980s and belongs to **Hardware Resources** (hardwareresources.com). The newest collection, Ivan, "offers a versatile aesthetic ideal for mid-century modern and Scandinavian spaces. The pulls blend a soft rounded grip with streamlined simplicity that enhances its harmonious appeal. With five standard pull lengths, two appliance handle sizes, and five contemporary finishes, Ivan is a minimalist's dream. It brings understated sophistication to modern interiors, delivering a

timeless yet contemporary charm," the manufacturer explains.

The new Folklore collection from **Berenson** (berensonhardware.com) invokes "trends and styles of our past for a nostalgic update to modern style". It's designed to complement traditional and farmhouse designs, and the forms and finishes are very familiar. Brushed gold is featured, along with weathered copper, matte black, brushed nickel and toasted bronze. The lines are clean, crisp and timeless. Berenson has added to its

popular Echo line this year and has also introduced the new Radial Reign collection that combines a textured bar with smooth posts. The material choices make for some dramatic looks when combining dark and light metallic colors.

Doug Mockett & Co. (mockett.com) has added the DP318 cabinet pull to its catalog. The pull has a unique silhouette described as "a striking fusion of form and function". The design features a protruding handle that's as ergonomic as it is eye-catching. It can be installed upward for a modern look or downward for a streamlined, minimalist aspect. The available finishes are Matte Black and Black Chrome and it is available in 8-3/4" and 12-15/16" lengths.

FUNCTIONAL HARDWARE

The other side of the coin is functional hardware – slides, hinges and the like. Here, the emphasis is on technology and utility rather than looks, although they can be important, too. But it's facets such as sensors and soft closing that are making the most waves.

New additions to the Aventos top system from **Blum** (blum.com) herald in the next generation of lift hardware that opens doors on upper cabinets. The system moves the doors up and out of the way, rather than just having them swing left or right. And part of the hoopla here for woodshops is the ease of installation, including



Häfele also presents its new 81-piece H25 designer collection.



Salice has updated its Edcedra pocket door system and added an online app for prepping and installing the hardware.

a system for locating screw holes accurately. Once they're in place, the doors can be adjusted from the front without having to remove cover caps. The line includes Aventos HL top, which lifts doors up parallel to the cabinet and is great for kitchens with high ceilings or in an appliance garage application. Next, the Aventos HS top swings up and over the cabinet, making it an ideal choice for wide cabinets with heavy, single doors. And Aventos HF top folds in half as the door moves up and out of the way. That makes it ideal for taller wall cabinets up to 48".

Lift systems are designed to increase safe access to high up cabinets, and **Rev-A-Shelf** (rev-a-shelf.com) has addressed that need in a different way. The new Yo-Yo Pull-down is a hinged shelf system that fits in an upper (wall) cabinet and has smooth, gas-spring assisted operation. It simply pulls down to give shorter people access to high cabinets. Yo-Yo has a side-mount design that maximizes storage space, and it's trimmable for cabinets from 14-1/2" to 36" wide. The sheet metal is finished in black, and the system has a high weight capacity. The shelves can be maple or shop-made.

New from **Häfele America** (hafele.com) is Hawa Concepta III pivoting hardware, which is a pocket door system that lets a homeowner close off a kitchen or other wall of cabinetry. The result is a clean look that can repurpose a room, or perhaps a space within a room. The hardware offers easy installation thanks to pre-assembly, and intuitive adjustments that can be carried out from the front, so no access panels are required. The hardware doesn't require a floor channel, and there's a version for cabinetry that has handle. An integrated soft closing mechanism takes over after a gentle push from the homeowner, and this moves the pocket door to its final open or retracted position. It can be handed left or right, and the wall recesses are concealed without the need for a separate cabinet.

The LADH is a heavy-duty lift assist damper from **Sugatsune America** (sugatsune.com). It can be used on seating or chest lids, or in situations such as store counters that raise to allow people through. What it does is



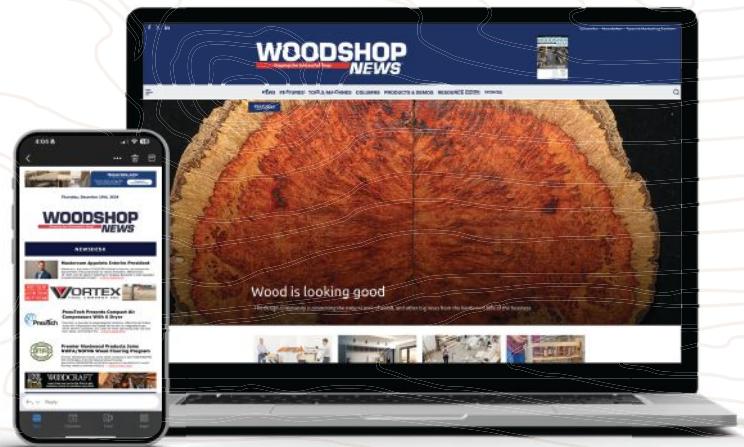
LADH dampers from Sugatsune America offer a soft close for countertops such as bar and restaurant pass-throughs or large chest lids.



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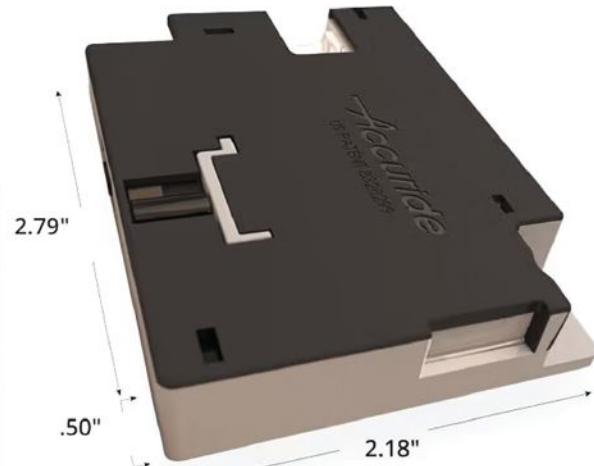
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Accuride makes card-activated secure locks for applications such as pharmaceuticals, jewelry and other high-ticket merchandise.



Rev-A-Shelf has introduced the Yo-Yo customizable pull-down shelving system that brings the contents of high-up cabinets within reach.



FurnSpin from Hettich can be used to swivel the end cabinet in a row to reveal doors or contents, or to spin a counter to create more workspace.



control the speed at which a hinged lid or panel drops back down after being lifted, which adds both convenience and safety. And it's also quiet. The damper can be used in pairs (or more) where each unit lifts up to 37 lbs., so it's ideal for retail environments, restaurant counters and bars. And it's available in different configurations and colors.

FurnSpin from Hettich America (furnspin.hettich.com) is a clever way of spinning a cabinet so that the contents are revealed or, with a very slight touch, concealed behind doors.

The concept is simple: a cabinet with a square base simply spins 180 degrees. It only works for cabinets that are as wide as they are deep, and for cabinets that are at the end of a row (or all by themselves). It rotates at a speed that keeps everything safely in place, and adds a little sophistication to designs. It can also be used to move countertops, creating a two-level, 90-degree workspace.

Among Hettich's other recent innovations is a battery-powered illumination system for Avantech drawers that is very dramatic when used with glass

drawer sides; the WingLine L hardware system for sliding doors that provides effortless opening; and advances in the Quadro high precision, tool-less drawer system that allows for five-way adjustment for height, side, depth, tilt and radial movement for perfect front panel alignment with minimal reveal widths.

New from **Grass America** (grassusa.com) is a clever Rear Anti-Tip System that gives cabinetmakers a simple, efficient, and lightweight way to help prevent tip-over accidents and enhance safety. It's engi-

neered so that only a single drawer can be opened at a time, locking the remaining drawers securely in place until the opened drawer is closed. It works by using a series of interconnected locking actuators that are mounted to a central spine at the back of the cabinet. The system eliminates the need for additional counterweights, so it reduces shipping costs and maintains the drawer's original extension capacity. And yes, it can be retrofitted onto existing cabinetry. The system can also be manually unlocked to allow for drawer removal if necessary and supports up to 50 lbs. of pull force.

Salice America (salice.com) has updated its Exedra pocket door system with several new features. This is a patented mechanism that is operated by a magnetically assisted motion-control system. It can be used on both wooden and aluminum-framed doors up to 88 lbs. Installers can now order it with hinges and Smove (a proprietary technology) for a decelerated closing, or push-to-open hinges for handle-less doors. Both versions



The new Ivan collection from the Jeffrey Alexander catalog by Hardware Resources works well in mid-century modern and minimalist spaces.

are available in nickel-plated or titanium finishes. There's also a new online configurator that provides all the necessary information for both prepping and installing. It includes application drawings and drilling plans, plus a 3D file of the assembly.

At last year's IWF, **Fulterer USA**

(fulterer.com) announced the new Compact 3000, a fully synchronized undermount drawer slide system with a load capacity of up to 130 lbs. The 'compact' reference is to height and width, not length – the 3000 comes in lengths of up to 28 inches. Fulterer notes that among its attributes are smooth action, high stability, and affordability.

The new 8850FM from **Knape & Vogt** (knapeandvogt.com) is a 200 lbs. capacity slide with soft-close that uses the company's patented Force Management technology. This system delivers the lowest opening pull force while ensuring effective damping closure that eliminates drawer slamming. The full extension drawer slide has both traditional and 32mm hole patterns that support industry standards, and it features an un-handed design with lever disconnect for easy drawer removal. It's recommended for drawers up to 42" wide.

From pharmaceuticals to paperwork and jewelry to sunglasses, cabinet shops are constantly being asked to build casework to store theft-risk items. **Accuride** (accuride.com) offers several secure solutions such as card-activated e-locks on doors and drawers. Older solutions such as magnetic and solenoid locks can drain power while still being vulnerable to subversion. The latest generation of e-locks are energy-efficient and can be set up with features such as tracking employee access, granting that access remotely, and automatically locking when closed. **W**



The Modern Metal collection from Richelieu Hardware was designed in Milan and adds a dash of color and drama to contemporary design.



The Masterworks of Color exhibit features Shaker pieces from public and private collections, including this Sewing Desk (Alfred, Maine. c. 1870), Blue Blanket Chest (Enfield, N.H. c. 1870), and Side Chair with Tilter Buttons (New Lebanon, N.Y. c. 1850).

Minnesota Woodworkers Expo slated for October

By Jennifer Hicks

The sixth annual Minnesota Woodworkers Expo, hosted by the Minnesota Woodworkers Guild, is scheduled for Oct. 11 at the Minnesota State Fairgrounds Progress Center in St. Paul, Minn. The event brings together woodworkers, makers, manufacturers, and retailers to share projects, information, knowledge and experiences.

"Last year's exhibition was held at the same location on the State Fairgrounds and hosted over 70 exhibitors and had over 2,000 attendees," says guild member Charles Finne who serves on the Expo committee.

"Exhibitors pay only a nominal fee designed to cover our costs for putting on the show and attendees come for free, although we do ask for and frequently get donations for our non-profit venture. Our post event survey of our exhibitors showed that everybody was pleased, and many suggestions were made for improving the event. Almost all indicated that they planned to return the following year."

There will also be a tool swap, kids' workshop, and Meet the Makers demonstrations.

Learn more at mnwwg.org.

EXPLORING SHAKER LIFE

"Masterworks of Color: Shaker Crafts and the Art of George Chaplin" opened Feb. 21 and will run through Oct. 5 at the New Britain Museum of Art in New Britain, Conn. Organized by consulting curator M. Stephen Miller, this exhibition is one in a series exploring Shaker craft in dialogue

with contemporary art.

"Joy in Shaker life was expressed through color," the museum states. "Stark black and white photographs led to the persistent misconception that Shaker life was not only dull, but stern and colorless. Life in the community was hard in many ways. Six days of every week were filled with work. Their surroundings were simple, devoid of luxury items. They lived apart from the rest of the world. Yet, austerity did not mean grimness."

"Shaker life offered converts security, shelter, sustenance, and support, while building a model of heaven on earth. The wooden objects in the gallery, large and small, and the textiles have color that was applied up to 200 years ago. These are and were a source of joy in Shaker life up to the present."

The exhibit also features paintings by artist George Chaplin. He had no direct connection with the Shakers, but his works are also an expression of the emotions that respond to color and coincide with the theme of the featured furniture, according to the museum.

"There is no 'narrative' in Chaplin's works. Their colors are at once diffuse when seen from afar, and intense when seen up close. There is indeed a 'conversation' here, a shared conviction that color is not only a journey to somewhere, but in itself a worthy, fulfilling, and thrilling destination. To surround oneself with color is to live joyfully."

Learn more at nbmaa.org. **W**

CALENDAR

Organizations sponsoring meetings, classes or shows of interest to professional or hobbyist woodworkers are invited to submit items to editorial@woodshopnews.com.

Include name, dates, location, description of event and a contact address or telephone number. Calendar items, which should be typed or printed clearly, must be received at least 60 days before the event.

Please note that fees, as listed, might not include materials or shop fees. Check with a specific class for further details.

— Compiled by Jennifer Hicks

ARIZONA

June 2-25 — Fundamentals of Traditional Woodworking I. Intro to wood technology, hand tool usage, design principles and creation of joinery. Fee: \$765. Location: Southwest School of Woodworking in Phoenix. sw-sw.org
June 30-July 24 — Fundamentals of Traditional Woodworking II. Building on skills taught in Fundamentals I, this class introduces power tools and concludes with a bench with mortise and tenon joinery and draw bore

joints. Fee: \$832. Location: Southwest School of Woodworking in Phoenix. sw-sw.org

July 28-Sept. 4 — Fundamentals of Traditional Woodworking III. Students will practice various joinery and construction techniques to build a Shaker-inspired table with dovetailed drawer, tapered legs, and mortise-and-tenon aprons. Location: Southwest School of Woodworking in Phoenix. sw-sw.org

Nov. 9-11 — Specialty Tools & Fasteners

St. in Tampa. tampawoodcrafters.org

MAINE

Ongoing — The Center for Furniture Craftsmanship offers year-round classes in woodworking to the highest degree of craftsmanship. One- and two-week workshops from June through October; 12-week Furniture Intensives; a nine-month Comprehensive; eight-week Turning Intensives, and Fellowships. woodschool.org

CALIFORNIA

Monthly — San Fernando Valley Woodworkers meetings are held on the third Thursday of each month at 7 p.m. at the Highland Hall Waldorf School's woodshop in Northridge. sfvw.org

Monthly — Society of Wood Manufacturing, a chapter of AWFS consisting of educators, manufacturers, hardware and industrial suppliers, and machinery dealers, meets during the second week of each month. For location and dates, visit awfs.org.
Monthly — San Joaquin Fine Woodworkers Association meetings are open to all experience levels at members' shops. For locations and dates, visit sjfwa.com.

MARYLAND

Monthly — The Howard County Woodworkers Guild meets the first Saturdays of the month at the Bain Senior Center at 5470 Ruth Keeton Way in Columbia from 9 a.m. to 12 p.m. Contact: Manny Flecker at aaron0641@hotmail.com.

MICHIGAN

Oct. 1-3 — Cabinet Makers Association's National Conference featuring keynote presentations, educational sessions, plant tours and more. Location: Westin Book Cadillac Detroit. cabinet-makers.org

FLORIDA

Ongoing — The Dunedin Fine Art Center is offering six-week woodturning classes at its Cottage Campus taught by AAW professional member Tony Marsh for beginners and intermediate-level participants. Full-day classes are held on Thursdays. Call 727-298-3322 or e-mail education@dfac.org.

Monthly — Woodcrafters Club of Tampa meets every third Thursday evening at 3809 W. Broad

MINNESOTA

Monthly — The Minnesota Woodworkers Guild meets on the second Tuesday of each month at various locations. mnwwg.org
Monthly — The Minnesota Woodturners Association meets on the first Saturday of each month (except

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July) in Plymouth. They also offer a wide range of classes for beginners and advanced turners. mnwoodturners.com

June 28-29 — American Craft Fest, hosted by the American Craft Council, featuring handmade objects by emerging makers from across the region. Location: Union Depot in St. Paul. craftcouncil.org

Oct. 11 — Sixth annual Woodworkers Expo, hosted by the Minnesota Woodworkers Guild, featuring over 70 exhibitors showcasing custom work and products, demos, and more. Location: Minnesota State Fairgrounds Progress Center in St. Paul. mnwwg.org

NEVADA

July 22-25 — AWFS Fair, featuring over 500 exhibitors, educational seminars, networking opportunities, and more. Location: Las Vegas Convention Center. awfsfair.org

NEW JERSEY

Monthly — The North Jersey Woodworkers Association meets the third Monday of every month. njwoodworkers.org

Monthly — The Professional Woodworkers Guild of Upper New Jersey meets the third Wednesday of every month. njwoodguild.com

NEW YORK

Monthly — The Woodworkers of Central New York holds meetings on the first Thursday of each month at 6:30 p.m. at the Belgium Cold Springs Fire Department in Baldwinsville. woodcny.org

Monthly — Northeast Woodworkers Association holds meetings on the second Thursday of the month at various locations in the Albany area. woodworker.org

Monthly — The Long Island Woodworkers meet on the first Wednesday of each month at 7 p.m. at the Frank Brush Barn of the Smithtown Historical Society in Smithtown. liwoodworkers.org

June 26-28 — Furniture Society Conference, "You Are Here: Makers, Place, & Impact", featuring workshops, artist talks, panel discussions, demos, and more. Location: Syracuse University. furnsoc.org

NORTH CAROLINA

Monthly — Triangle Woodworkers Association meetings are held on the third Tuesday of each month at 7 p.m. at Klingspor's Woodworking Shop. Location: MacGregor Village in Cary. trianglewoodworkers.com

Monthly — Charlotte Woodworkers Association meets the third Tuesday of each month, except December, at 6:15

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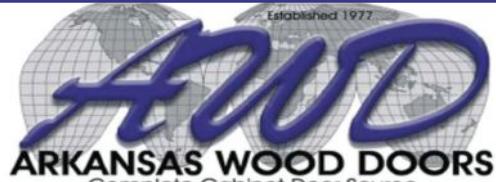
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Oct. 25-29 — Fall High Point Furniture Market. The furniture industry trade show features showroom tours, vendors, speakers, educational seminars, and networking events. highpointmarket.org

OHIO

Ongoing — Cincinnati Woodworking Club meets the second Saturday in the months of Jan., March, May, Sept. and Nov. from 8:30 a.m. to 12:30 p.m. at the E.B. Mueller in Reading. cincinnatewoodworkingclub.org

PENNSYLVANIA

Monthly — Lehigh Valley Woodworkers Guild meets at 6:30 p.m. every third Tuesday of the month at the Woodcraft in Allentown. Various craftspeople provide presentations on their woodworking techniques. lwwg.com

RHODE ISLAND

Nov. 7-9 — 30th annual Fine Furnishings show featuring fine handcrafted furniture and other artwork for the home.

Location: WaterFire Arts Center in Providence. finefurnishingsshows.com

SOUTH DAKOTA

Monthly — The South Dakota Woodworkers Guild meets the last Thursday of every month, except August, at various members' shops. The club has hand tool and wood-turning groups. Learn more at sdwoodworker.org.

TEXAS

Sept. 13-14 — Texas Woodworking Festival, an annual event featuring demonstrations, classes and lectures. Location: Palmer Events Center in Austin. texaswoodworkingfestival.com

Oct. 1-3 — National Hardwood Lumber Association Annual Convention. Location: Marriott Rivercenter in San Antonio. nhla.com

VIRGINIA

Oct. 10-13 — Society of American Period Furniture Makers' annual conference, featuring presentations, networking opportunities, and the Cartouche Award banquet. Location: Williamsburg. sapfm.org **W**

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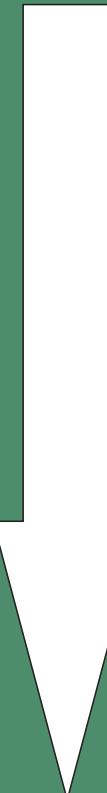


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WOODSHOPNEWS

Rev-A-Shelf extends support for HFOT

Rev-A-Shelf renewed its partnership with Homes For Our Troops (HFOT) at the Kitchen & Bath Industry Show (KBIS) in February, marking another chapter in its decade-long collaboration with an organization that builds and donates specially adapted custom homes nationwide for severely injured post-9/11 veterans.

Each home is equipped with over 40 major special adaptations and exceeds ADA compliancy standards, providing full accessibility for the veteran. These adaptations include wider halls and doorways; automatic door openers; roll under sinks, stove tops, and counters; pull down shelving, generators and safe rooms, all designed to help the veteran live independently, according to the HFOT.



Bill Ivey of Homes For Our Troops with Rev-A-Shelf's (from left) Jennifer Roche, Ryan Jones, Creighton Jones, Steve Jones Jr. and Craig Jones, and Army Sergeant Juan Arredondo, a veteran and HFOT home recipient.

Bill Ivey, HFOT's executive director, and Steve Jones Jr., general manager and vice president of consumer sales for Rev-A-Shelf, led a signing the event at KBIS, highlighting the profound impact of accessible storage and organizational solutions in restoring independence for veterans.

"The signing event brought together company leaders and HFOT representatives and honored veterans to celebrate a partnership that has helped transform lives through specially adapted custom homes," Rev-A-Shelf explained in a statement.

"As part of the celebration, HFOT presented Rev-A-Shelf with a special plaque commemorating their 10 years of partnership. The plaque was crafted by Marine staff sergeant



(From left) Rev-A-Shelf's Steve Jones Jr. and Craig Jones at the signing event with Bill Ivey of HFOT.

Omar Milan, a veteran and HFOT home recipient. The HFOT team toured the booth and reviewed the latest accessible products designed to improve everyday functionality for those with mobility challenges.

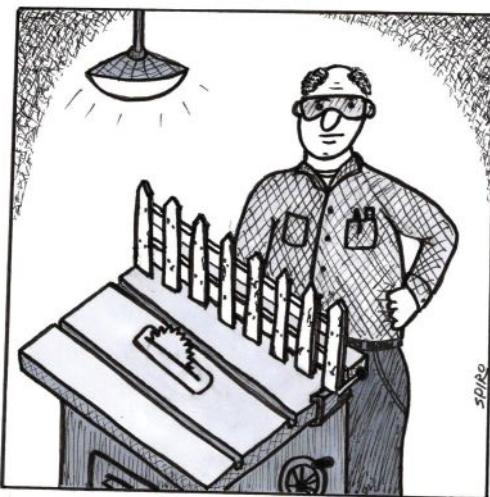
"Attendees had the opportunity to hear inspiring stories from veterans whose lives have been transformed through HFOT's mission, showcasing how thoughtful design can make everyday tasks more manageable for those with life-altering injuries."

The event concluded with the official signing. Moving forward, Rev-A-Shelf says it will continue to supply accessible storage and organizational solutions, helping create safe and functional living spaces for veterans nationwide.

Learn more at rev-a-shelf.com and hfotusa.org. **W**

60 Grit

Rough humor by Steve Spiro



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