Scribe Molding Fit Check: Gap Verification & Adjustment Procedure

1.0 Objective & Quality Standard

The objective of this procedure is to ensure that scribe molding is fitted flush to the wall and cabinet face, with a consistent 1mm ±0.5mm reveal gap between the molding and the cabinet face. This prevents visible gaps, ensures a seamless finished appearance, and eliminates the need for excessive caulking or touch-up.

All scribe molding must be cut, fitted, and verified against this standard before final fastening. Any deviation beyond the tolerance must be corrected or the part reworked.

2.0 Required Tools & Gauges

- Digital caliper (0-150mm range, 0.01mm resolution)
- Feeler gauge set (0.5mm to 2.0mm)
- Combination square or carpenter's square
- Pencil (fine tip, non-marring)
- Scribe tool (compass or contour gauge)
- Fine-tooth coping saw or jigsaw with fine blade
- Sandpaper (120 and 220 grit)
- Clamps (quick-grip or bar clamps)
- Flashlight or work light for shadow inspection
- ShopDocs QA checklist (digital or printed)

3.0 Safety & Material Handling

- Wear safety glasses and cut-resistant gloves when cutting or sanding scribe molding.
- Handle finished panels with clean, rubber-grip gloves to prevent oil transfer or scratches.
- Ensure scribe molding is stored flat on a clean, padded surface to prevent warping or damage.
- Use a dust mask when sanding to avoid inhaling fine particles.
- Keep work area clear of debris and tools to prevent tripping hazards.

4.0 Step-by-Step Procedure

1. Inspect the scribe molding for any visible defects (cracks, chips, warping) before fitting. Reject any defective pieces.
2. Position the scribe molding against the cabinet face and the wall, ensuring it is oriented correctly (top edge flush with cabinet top or side).
3. Using a combination square, verify that the molding is aligned parallel to the cabinet face. Adjust as needed.
4. Use a scribe tool or contour gauge to trace the wall profile onto the molding. Ensure the scribe is held perpendicular to the wall for an accurate transfer.

5. Remove the molding and cut along the scribed line using a fine-tooth coping saw or jigsaw. Cut slightly outside the line (0.5mm) to allow for fine sanding.

6. Sand the cut edge with 120-grit sandpaper, then finish with 220-grit to achieve a smooth, burr-free surface.

7. Dry-fit the molding back into position. Use clamps to hold it in place without damaging the finish.

8. Using a feeler gauge, measure the gap between the molding and the cabinet face at three points: top, middle, and bottom. The gap must be 1mm ±0.5mm at all points.

9. Shine a flashlight behind the molding to check for light bleed (indicating gaps). Any light visible indicates a gap larger than 0.5mm and requires adjustment.

10. If the gap is out of tolerance, mark the high spots with a pencil and sand or recut the molding accordingly. Repeat the fit check until the gap is within specification.

11. Once the fit is verified, remove the molding and apply a thin bead of construction adhesive to the back (if specified by the installation plan). Do not apply adhesive to the cabinet face.

12. Reinstall the molding, clamp, and allow adhesive to set per manufacturer instructions. Wipe away any excess adhesive immediately with a damp cloth.

5.0 Verification & Defect Reporting

1. After final installation, perform a final visual inspection using a flashlight to confirm no light bleed. Measure the gap again with a feeler gauge at all three points.

2. If any gap exceeds 1.5mm or is less than 0.5mm, flag the unit for rework. Remove the molding, adjust the cut, and reinstall.

3. If the molding is damaged during fitting (cracked, chipped, or scratched), red-tag the piece and replace it with a new one. Do not attempt to repair cosmetic damage.

4. Log all out-of-tolerance defects in the ShopDocs QA module, including the location, gap measurement, and corrective action taken. This data is used for root cause analysis and process improvement.

5. If three or more consecutive scribe moldings fail the fit check, stop the line and notify the QA supervisor. Investigate potential issues with the wall condition, cabinet alignment, or cutting process.