



Crypton Super Furniture: Manufacturing Standards

Frame:

Upholstered (non –exposed) frame shall be sound kiln dried (7%) mixed hardwood for strength and dimensional stability. Plywood or manufactured woods that meet or exceed 5/4 hardwood specifications may be used in appropriate frame applications. Plywood parts, when used, shall be cut from hardwood plywood for strength.

Exposed Wood:

Any exposed wood trim or integral exposed wood legs shall be milled from kiln dried hardwood, premium grade selected free of visual and structural defects. Wood bases are to be doweled and glued. Finger joints are to be used in appropriate areas. Seat boards are to be ¾” thick with breather holes. All frames must be square and leveled.

Frame Assembly:

All stress joints shall be connected utilizing one of the following methods. Double doweled, screwed and glued – Corner block, glued and heavy duty frame staples. Critical joints will be reinforced with corner blocks or metal brackets. Glue shall be polyvinyl acetate or equivalent. Legs and casters shall be fastened to the frame with 5/16” hanger bolts or threaded stems into a steel t-nut imbedded in the hardwood frame structure.

Cushion Foam:

Connor Series (SP7897)
2.3 HR 24 lb Foam Core
½” 1.1 22 lb Foam Crown Pad
¾” 1.1 15 lb Foam Wrap
1 oz. Fiber Wrap

Hugo Series (SP7699)
1.8 HR 24 lb Foam Core
½” 1.1 22 lb Foam Crown Pad
¾” 1.1 15 lb Foam Wrap
1 oz. Fiber Wrap

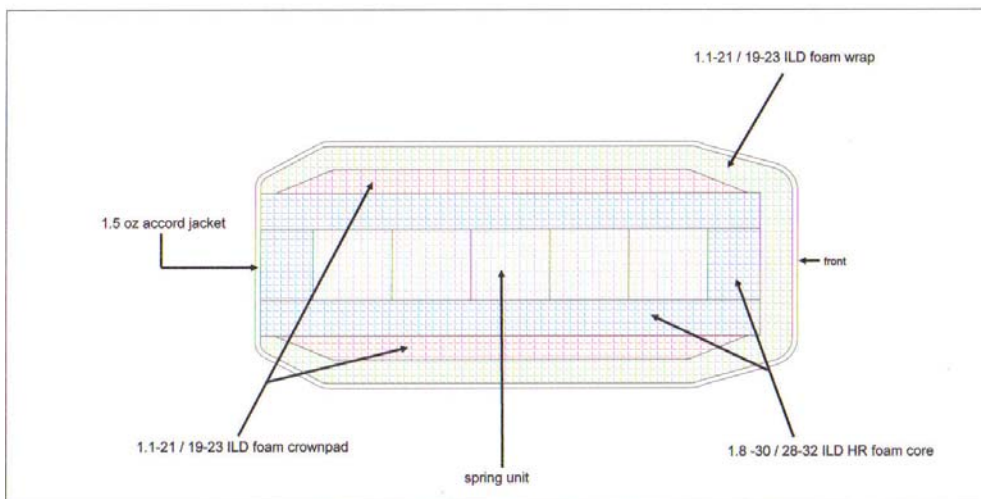
Charlotte Series (SP8141)
1.8 HR 24 lb Foam Core
½” 1.1 22 lb Foam Crown Pad
¾” 1.1 15 lb Foam Wrap
1 oz. Fiber Wrap

Foam must meet the following minimums. All cushion foam shall be high resiliency (HR) and a minimum of 1.8 density and various ILD ratings as prescribed by each product. Each product will be prescribed with proper density and ILD ratings to ensure optimal performance. All foams shall be compliant with California Technical

Bulletin 117 (TB-117). All cushions must have enough push side to side to prevent fabric wrinkles. All cushion crown patches must be HR foam.

Marshall Unit Cushion

Kellex All Foam Construction Spring Seat



Back Pillow Foam :

Foam density must be at minimum 1.5 or above, ILD range is 15 to 20lbs. TB 117 is required.

Arm and Back Foam:

In arm density 1.1 with ILD range of 32 to 36 lbs
 Top Arm Foam density 1.5 with ILD range of 45 to 55 lbs.
 In Back Foam density 1.1 with ILD range of 15 to 21 lbs.

Back Pillow Fiber Construction:

Fiber denier range is 7 to 15. Fiber construction is conjugate hollow “siliconzed” with fiber length of 2 to 2 1/2 inch blown inside an 1 1/2 oz accord casing. A divider is to be used if the height is over 20”. Two dividers are to be used if height is over 28”.

Fiber Filled Backs with Buttons:

Backs with buttons must be regulated out so fiber is evenly distributed creating a “nested” effect. Button alignment tolerance is plus or minus 1/8” from designated position. Backs must be regulated evenly with special attention to corners and ears, making sure they are properly filled. Regulator marks should not be visible.



Upholstering with Crypton Fabric:

Breather panels or grommets are required on Crypton Super Fabric. Replacement of breather panels and grommet will be where the zipper panels are currently on cushions. **Note:** The breather panel cannot be visible from the top view.

Cutting Standards:

All vertical stripes must match with a tolerance of plus/minus 1/8". Horizontal is to be matched with a tolerance of plus/minus 1/8". Outside backs and skirts will be reversed by cutting to match inside back on styles requiring match. Backside of ottomans will be reversed by cutting.

Spring-Up Standards:

Springs must be attached within plus/minus 1/2" from desired spacing. Front edge of spring edge constructions may be no more than 1/4" out of straight line in the horizontal (in & out) or vertical (up & down). Clips must be closed with hammer after springs are inserted. Burlap/Tyvar material must be tight. Webbing must be under tension. Edge molding requires two staples on each end and one staple between each clip. Deck pad must not hangover edges more than 1/4". Arm cardboard must not hangover in front, back, or bottom and must staple to the upper half of the arm nail on. Arm cardboard must not "oil-can". It must be bent properly and sufficiently stapled to each arm-filler. No glue allowed on legs.

Seat Springs:

8 gauge sinuous wire springs must be attached with insulated spring clips and spaced no more than 5" apart and must be secured to each other with the use of two steel insulated tie wires. The ends of the sofa/loveseat/chair are to have double springs. Springs are covered with a heavy duty batting material. **Note: Loop size is medium**

Back Springs:

10 to 12 gage sinuous wire springs must be attached with 2 steel insulated tie wires. Note: Tie wire cannot hit in-back upright. Semi attached back cushion designs are to be constructed over nylon webbing or no sag wire support. Loop size is dictated by style.

Finish Quality Standards

No glue allowed on legs to be finished. Show wood is sanded with 120 or 150 grit paper to smooth. Final sanding should be with 150 grit paper to smooth.

Finishing Process Standards

Raw wood is not acceptable. All Show wood must be checked for defects and proper fit prior to finishing. Staining must be uniform. Not streaked or blotched. Sealer or lacquer runs are not acceptable. "Caked" deposits on post are not permissible. Extra steps must be taken to tone/shade dark streaks in raw wood. All finish orders should be checked against "sample board" to insure consistent finish.