

CASE GOODS STANDARD CONSTRUCTION SPECIFICATIONS

A. GENERAL CONSTRUCTION

- Case goods are manufactured with hardwood plywoods, with hardwood solid edges.
- All exposed edges are finished with solid wood.
- All gables, vertical surfaces, end panels, and kicks are plywood hardwood with solid wood edges
- Joints are mortised and tenoned, doweled or blocked, glued and pinned, following commercial construction standards.
- All case table and chair joints are glued with approved PVA assembly adhesive that conforms to the ASTM D-905-89 test requirements of average block shear strength of not less than 2800lbs per square inch.
- All corner blocks and braces are made of plywood.
- All structural members are glued and screwed, or stapled, in place.
- All excess glue is cleaned from surfaces exposed during normal use.
- Tops are surfaced with custom matched high-pressure laminate 0.030" thick, that conforms to Federal Specifications LP508H. Laminate adhesives are PVA's. Top cores are solid wood. Top edges are unbanded solid wood.
- All end panels are solid wood.
- Back panels are flush to back of case piece. Optional: back panels can be recessed 3/4" to allow cases to fit over electrical plugs and cords.
- Casters and base blocks are glued and screwed to allow for free movement of caster.

B. MATERIAL REQUIREMENTS

- All wood is kiln dried to a moisture content of 6 - 7 1/2 % and conditioned to a stress free board. Ensures firm bonding of joints and minimizes distortion and warping in varied climate conditions.
- Unexposed solid wood parts are premium grade, free of knots, decay, cracks, and other defects that would adversely effect strength.
- Exposed solid wood parts are stained in uniform color to match Laminate.
- Panels are manufactured with balanced, multi-directional plied construction.

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- Panels are manufactured with balanced, multi-directional plied construction.
- Glues and Adhesives are tested for viscosity, PH, reactivity, and solids content to insure correct formulation and holding strength.
- Back panels are 1/8" hardboard fastened securely by gun staples. Fasteners are flush with the outside back and do not swell, split, or protrude through finished surfaces. Back panels are not a structural component of the case.
- Drawer fronts are hardwood plywood with solid wood edges and solid wood vertical planes. Use of solid hardwood plywood eliminates warping, and allows for more secure hinging. Drawer Box is constructed of contract grade plywood. Drawer bottoms are 1/8" hardboard.
- Drawer guides are heavy-duty side mounted, with a 75 lb load capacity. Guide surfaces are double-dipped and epoxy coated to prevent corrosion.
- Hardware has rust and tarnish proof finish

C. WORKMANSHIP

- Doors are aligned to ensure uniform clearance and operation free of noise and / or rubbing.
- Drawers are custom fitted to insure free running action with no binding, sticking, rattling, or squeaking. Drawer guides and runners are securely fastened and properly positioned to assure correct drawer alignment.
- Drawer interiors and other storage areas are sanded smooth and are free of glue. Sides, ends, and bottoms, are free of splinters, snags, slivers, staples, nails, and screws.
- All hardware, including hinges, pulls, and glides, are attached and fitted to operate properly and serve their purpose.
- Miter joints are square, flush, tight, and well glued. Exposed case front joints are tight.
- Case tops are attached to the case with screws.



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- Assembly and hinge screws are properly seated and driven flush with the hinge flange.
- All glides and casters are properly attached.
- All moldings are nailed from the back of the panel if possible. Face nails or brads are driven flush and nail holes are filled.

D. APPEARANCE AND FINISH

- Finishing is accomplished with the following process:
 - A uniform wet coat of pre-stain is applied overall.
 - A uniform wet coat of body stain is applied overall.
 - A uniform wet coat of sealer is applied over all.
 - Once thoroughly dried, the coat of sealer is sanded.
 - Dark areas are highlighted. Low areas are brushed out.
 - A uniforming stain is used to blend overall color.
 - A second coat of sealer is applied overall.
 - Once thoroughly dried, the second coat of sealer is applied.
 - A uniformed wet coat of 35 sheen lacquer is applied overall.
 - Glaze is dry brushed to match the color standard and raw edges are touched up.
 - A second coat of 35 sheen lacquer is applied.
 - A third coat of 35 sheen lacquer is applied.
- Edges are finished to be compatible with case exterior.

E. PERFORMANCE

- Drawers and doors are fitted and aligned to operate smoothly under various atmospheric conditions
- All drawers, doors, and other operating parts are properly fitted and aligned to operate smoothly without loose or sloppy action.
- Hardware is straight and firmly attached.



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F. FEATURES OF INDIVIDUAL ITEMS

1. GENERAL

- All case goods can be custom ordered to size specification.
- All case goods can be designed to meet requirements of specific projects.
- All case good stains are custom, and matched to top-surface laminate.
- Case good hardware is available in standard or custom selection.

2. HEADBOARDS

- Panel headboards are wall hung.
- Custom legs are available upon request.

3. NIGHT STANDS

- Single (1) and Double (2) Drawer Night Stands are available in a variety of sizes and designs.

4. ARMOIRES

- Armoires are available with or without doors. Standard design includes three drawers in the lower portion. Interior shelving is optional.
- Armoires will accommodate televisions up to the size of most 27" TV's.
- Doors swing fully open against the side of the case to provide unobstructed viewing.
- Doors have two interior catches, to hold them firmly in place when closed.
- Interior back panel is finished to match case.

5. MIRRORS

- Mirror frames are constructed of solid hard wood.
- Mirror glass is 3/16" plate glass with copper electroplate backs to protect silver surface.

6. DESKS

- Standard desks include a center stationary drawer.
- Desks are available in varying sizes, with or without drawer, and can be designed to meet requirements of specific projects.

7. OCCASIONAL TABLES

- Occasional tables include Coffee Tables, End Tables, Sofa Tables, and Parsons Tables.