

# *Thomasville*®

## CONTRACT

### Harmony: 48585 - Standard Construction

Available in the following finishes: 48585: African Walnut

#### A. GENERAL CONSTRUCTION

- ❑ Joints are mortised and tenoned, doweled or blocked glued and pinned, following the best practice of commercial construction.
- ❑ All case table and chair joints are glued with an approved PVA assembly adhesive that conforms to the ASTM D-905-89 test requirement of average block shear strength of not less than 2800 lbs. per square inch.
- ❑ All corner blocks, braces and screw cleats are glued and reinforced with staples, nails or screws.
- ❑ All corner blocks and braces are made of solid wood.
- ❑ All structural members are glued and screwed or stapled in place.
- ❑ All excess glue is cleaned from surfaces exposed during normal use
- ❑ Contract design case tops are surfaced with custom matched high-pressure laminate .030" thick that conforms to Federal Specification LP508H. Laminate adhesives are either urea resins or PVA's. Top cores are 45 lb. density industrial grade particle board in accordance with specification ANSI A208.1-1993. Tops are edge banded with a 1 ½" wide piece of ¾" hardwood lumber.
- ❑ All end panels are a three-ply veneer construction with a 45 lb. density particleboard core. Exposed end panel edges are lumber banded on the front edge.
- ❑ Back panels on contract design cases are recessed allowing cases to fit snugly against walls over electrical plugs and cords, maximizing the space in the room.
- ❑ Casters and base blocks are glued and screwed allowing for free movement of the caster.
- ❑ All cases over 60" have a center foot.

#### B. MATERIAL REQUIREMENTS

- ❑ All wood is dried to a moisture content of 6-7½ % and conditioned to produce a stress free board. This process keeps distortion and warping to a minimum and ensures firm bonding joints in widely varying climate conditions. Moisture is checked using ASTM D-\*143.
- ❑ Exposed solid parts are premium grade hardwood free of knots, decay, season cracks, mineral streaks, bark, warp, twist or any other defect that adversely affects strength or appearance. Loose knots and wormholes are not permitted.
- ❑ Unexposed solid parts are select hardwoods free from knots, decay, warp, twist or any other defect that adversely affects strength.
- ❑ Exposed sliced cherry face veneers are selected based on good texture and uniform color. Veneers are book or slip matched on case fronts.
- ❑ All veneered panels are constructed with waterproof glue under controlled pressure. Panels are manufactured with balanced multidirectional plied construction.
- ❑ Glues and Adhesives are routine tested by Thomasville's Quality Control Lab for a variety of factors including viscosity, PH, reactivity and solids content to insure they are formulated correctly and provide the required 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 with cherry veneer. Drawer sides and backs are constructed of Baltic Birch plywood joined front and rear with English style dovetails. English dovetails provide more secure interlocking than other dovetail methods. In addition English dovetails provide the maximum glue surface, compared to other construction methods such as French dovetails. Drawer bottoms, constructed of 3.6-mm plywood, are secured in groves front side and back using hotmelt adhesive for maximum rigidity and durability. Drawer interiors are sanded and finished with a coat of sealer and an UV polyester topcoat insuring a smooth interior drawer surface.
- ❑ Drawer guides on contract design cases are heavy duty side mounted metal with a 75 lb. load capacity. The guide surfaces are double dipped epoxy coated to prevent corrosion.
- ❑ Particleboard Standards
  - All particle board meets ANSI A208.1-1993
  - Tops with particleboard cores are lumber banded on three or four sides with edge banding on the back edges if they are not lumber banded.
  - Cases have no exposed particleboard.
  - Particle board used in doors is banded on all four sides.
- ❑ Hardware has a rust and tarnish proof finish.
- ❑ Packaging materials are custom designed for each item to minimize shipping damage. The Thomasville Testing Lab conducts various packaging materials tests based on the National Safe Transit Association “Pre-Shipment Test Procedures”. These tests include impact simulation, vertical drop testing and over the road vibration simulation. These tests measure the effectiveness of the carton as well as the structural integrity of the case itself. Changes are made in packaging or case constructions if weaknesses are found.

### **C. WORKMANSHIP**

- ❑ Doors are properly aligned to insure uniform clearance and operation free of rattle, squeak or rubbing. Catches are properly aligned and installed with a minimum requirement of two catches on all but small dresser doors.
- ❑ 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.
- ❑ Cross grain sanding, machine marks, splits, chip outs, veneer checking, or roughness are not permitted on the surface of the finished product.
- ❑ Drawer interiors and other interior storage compartments are sanded smooth and are free of glue or lacquer runs. Sides, ends and bottoms are free of splinters, snags, slivers, staples, nails and screws.
- ❑ All hardware including hinges, pulls, latches, catches and glides are attached and fitted to operate properly and serve their purpose during transit and use.
- ❑ Miter joints are square, flush, tight and well glued. Exposed case front joints are tight not exceeding 1/64”.
- ❑ Case tops are attached to the case with screws allowing the top to be pulled down tight against the case.
- ❑ Interior screws are flush or countersunk to the surface of the part where used.
- ❑ Assembly and hinge screws are properly seated and driven flush with the hinge flange.
- ❑ All glides and casters are properly attached.
- ❑ All molding and overlays are nailed from the back of the panel if possible. Face nails or brads are driven flush or set and nail holes filled.

### **D. APPEARANCE AND FINISH**

- ❑ Finishing is accomplished with the following eighteen step process.

1. Pre-stain is applied to tie in hardwood solids to match cherry veneers.
  2. A uniformed wet coat of pre-stain is applied overall.
  3. A uniformed wet coat of body stain is applied overall.
  4. Pre-seal is applied to solid wood parts and end grain that may go dark at glaze.
  5. A uniformed wet coat of sealer is applied over all.
  6. Once thoroughly dried the coat of sealer is sanded.
  7. Dark areas are highlighted with scotchbrite. Low areas and corners are brushed out.
  8. A uniforming stain is used to carefully blend overall color, tying in wood solids to cherry veneers.
  9. A second coat of sealer is applied over all.
  10. Once thoroughly dried the second coat of sealer is sanded.
  11. Pad stain is hand padded onto the case. The material is customized as needed to match the color standard.
  12. A uniformed wet coat of 20 sheen lacquer is applied overall.
  13. Glaze is dry brushed to match the color standard and raw edges are touched-up.
  14. A second coat of 20 sheen lacquer is applied.
  15. A third coat of 20 sheen lacquer is applied.
  16. Interior stain is applied prior to final assembly.
  17. All uprights and parting rails are padded with stain.
  18. Drawer dovetails are stained prior to drawer assemble for checker-board effect.
- ❑ Uniformity of color is achieved between different manufacturing locations and from one production run to the next. Each item is compared to an approved color case to insure a consistent finish match.
  - ❑ Color comparisons are made in the Thomasville testing lab to verify the color match of each batch of finishing material.
  - ❑ Interior surfaces of compartments and drawers are free of dirt, dust, shavings and other foreign matter before finishing.
  - ❑ Edges and backs of doors and drawers edges are finished to be compatible with the case exterior.
  - ❑ The finish has passed durability testing conducted by the Thomasville Testing Lab based on the guidelines of ASTM Test D 1308-87, which is the “Standard Test Method for Effect of Household Chemicals on Clear, and Pigmented Organic Finishes”. This test demonstrates that the finish is colorfast and resists staining from extended exposure to common household products.

## **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
- ❑ Doors and door hinges operate smoothly and quietly without binding, rubbing or rattling.
- ❑ Drawers have passed the ANSI/BIFMA X5.5-1998 Section 7 test. This test requires drawers loaded with 51.5 lbs. of weigh to open and closed for 50,000 cycles with no structural breakage or lose of serviceability.
- ❑ Doors have passed the ANSI/BIFMA A156.9-1994 Section 4.3 test. This test requires doors to open and close 100,000 cycles with no structural breakage or lose of serviceability.
- ❑ Numerous precautions are taken throughout the production process, from design to lumber drying to panel construction, to insure warping does not occur once a case is completed.
- ❑ Hardware, both trim and functional, is straight and firmly attached.

## **F. Features of Individual Items**

### **1. Chairs**

- ❑ All chair designs have passed a cycle test that simulates a 200 lb. person rocking back and forth in the chair 15,000 times, with zero failures. This rocking is the motion that exerts the most strain on the dowel joints between the front posts, side rails, and the back post of the chair giving a relative indication of the chair's structural integrity.
- ❑ Chair side rails contain three 3/8" grooved birch dowels in a 20 1/4" wide rail. The interior sides of the chair rails contain multi-grooves with four corner blocks matched to the grooves. Corner blocks are PNA glued and screwed into place. One corner block is screwed into the back post.
- ❑ Chair joints are properly angled and clamped tight. No openings are permitted in the joints.
- ❑ Leg stretchers, which enhance the structural strength of the chair by providing increased stability to the legs, are machined (chucked) for a tight fit and glued into place.
- ❑ Seat and back cushions are tailored and fit properly to the frame.

### **2. Headboards**

- ❑ Panel headboards are available in both wall-hung (sizes 4/6, 5/0 & 6/6) designs. Mounting instructions are included for wall hung models.
- ❑ Custom fitted leg kits are available to convert wall-hung headboards to free standing.

### **3. Night Stands**

- ❑ Both one drawer and two drawer night stands are available in a variety of sizes and designs.

### **4. Armoires**

- ❑ Armoires are available with and without doors. Both designs have two shelves in the upper portion (one adjustable, one stationary) and three drawers in the lower portion, providing ample storage space
- ❑ Well-organized and spacious design allows for the ultimate in function and versatility.
- ❑ The contract design 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.
- ❑ Adjustable glides are installed on all four corners of the case. These glides allow precision leveling of the cases to insure that doors hang evenly and operate smoothly.
- ❑ Doors have two catches to hold them securely in place when closed.
- ❑ Since the back panel is visible through the armoire opening the interior side of the back panels is finished to match the case.

### **5. Mirrors**

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

### **6. Desk & Writing Tables**

- ❑ Writing tables include a center stationary drawer
- ❑ An electronic data port unit that attaches to the desk or writing table is available. This unit is installed on site to be certain positioning is compatible with the outlet location in the room.
- ❑ Custom writing tables in varying sizes, with and without a drawer, can be designed to meet the requirement of specific projects.
- ❑ Writing tables are shipped KD (without the legs attached) minimizing freight damage and reducing freight costs.

### **7. Occasional Tables**

- ❑ The occasional table collection includes cocktail tables, end tables, sofa tables and activity tables. All feature both veneer and lumber banded laminate tops.
- ❑ Contract design occasional tables are shipped KD (without the legs attached) minimizing freight damage and reducing freight costs.