



FURNITURE-GENERAL QUALITY CONSTRUCTION FOR CASEGOODS QUOTED

1. Solid Wood: Lumber shall be kiln dried, plain sawn Red Oak. Laminations consist of planks no less than $\frac{3}{4}$ inch, no more than 4 inches in width. No splices, loose knots, torn grain, snakes, checks, cracks, splits or defects of any kind shall be permitted. All panels are precision end trimmed on width and length, all surfaces sanded to 150 grit. All panels are color matched for color consistency. Lamination: Planks shall be edge-glued using Jowatt Jowacoll 10322 aliphatic resin glue. The glue joints shall be stronger than the wood itself. Moisture content at time of assembly shall be kept between 5% and 7% inclusive. All joints shall be true and tight and securely glued in place. Surface of joints must fit accurately with no openings or splintering. Joints shall have 100% glue coverage. No starved joints will be allowed. Excess glue shall be neatly and thoroughly cleaned from all surfaces exposed to view. All panels must be matched for color consistency.
2. Plywood Veneer Panels: Full veneers are selected of plain-sliced natural wood veneers. Composition boards utilized: Particleboard Specification: ANSI A208.1-1979 may be used on door (s) for stability. Hardwood Plywood US Department of Commerce Standard PS-51-71. Type II. All plywood veneer panels must be veneer core $\frac{3}{4}$ ", providing superior screw holding ability.
3. High Pressure Plastic Laminate: Plastic laminate shall be a minimum of .02 with a typical thickness of .031 laid up on industrial grade particleboard. Color to be selected from manufacturer standard high-pressure plastic laminate colors of the quality of Wilsonart or Formica standards. $\frac{1}{4}$ " solid wood edging will be required on all four sides; backing must be gator ply .020 for stability.
4. Drawer Construction: All drawer sides of $\frac{1}{2}$ " thick 9-ply hardwood plywood, 4 sided with interchangeable face fronts. Drawer Bottoms of $\frac{1}{4}$ " hardwood plywood, stapled and glued for rigidity. Drawers will be assembled with finger dovetail joints and drawers will run on side-mounted heavy duty metal ball bearing guides with 100# test load capacity and come with drawer stops.
5. Standard Internal Construction: The interior framing inside the furniture items consists of veneer core plywood parting rails doweled, glued, and screwed to end panels where required. The bottom and other horizontal panels are doweled, glued, and screwed to the end panels. Top will be screwed to the cabinet. All cabinets have reinforced solid hardwood corner blocks glued and screwed into the corners of the base.

*Optional Internal Construction: The interior framing inside the furniture items consists of a 4-sided hardwood frame at every drawer level. Each frame will be lap jointed, glued and then stapled in all four corners. Each frame must be then glued and screwed to the interior cabinet sides. The base is glued and screwed of solid panel $\frac{3}{4}$ " and glued and screwed to cabinet. Top will be screwed to the cabinet. All cabinets have reinforced solid hardwood corner blocks glued and screwed into the corners of the base.
6. Finishing: Products must be finished to match stain color chosen, lacquered with a 30% high solid pre-catalyzed 40 sheen lacquer, HAPS and VOC's compliant with a minimum of 2 coats for durability.